

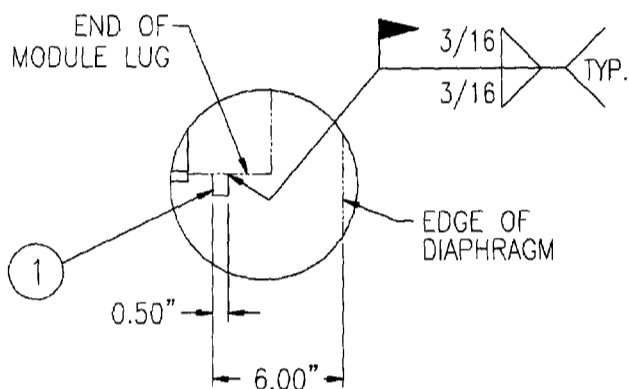
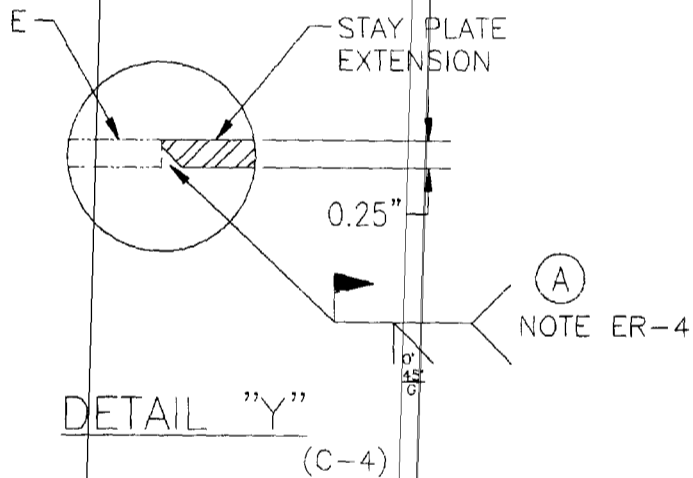
*DRAWING PACKAGE 2005*

## BILL OF MATERIAL

REF.	Drawing #	QTY.	MAT'L	DESCRIPTION	S.L.
1	A-10031481	24		INBOARD BASKET SUPPORT BAR	SL
2	C-105534	24		"A" STAY PLATE EXTENSION ASSEMBLY ASS'Y #7	SL
3	C-105534	24		"B" STAY PLATE EXTENSION ASSEMBLY ASS'Y #8	SL
4	C-105534	24		"C" STAY PLATE EXTENSION ASSEMBLY ASS'Y #9	SL
5	C-105534	24		"D" STAY PLATE EXTENSION ASSEMBLY ASS'Y #10	SL
6	C-105534	24		"E" STAY PLATE EXTENSION ASSEMBLY ASS'Y #11	SL
7	C-105534	24		"F" STAY PLATE EXTENSION ASSEMBLY ASS'Y #12	SL
8	D-11-66473	24		BASKET SUPPORT AT SHELL	SL
9	B-3-78067	24		COVER ASSEMBLY	SL
10	P-10-30765	192	3222	0.63 X 1.25 AW WELD STUD	SL
11	P-10-25412	192	32D5	0.63 HEX NUT	SL
12	P-10-25413	192	3214	0.63 WASHER	SL

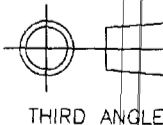
## NOTES TO ERECTOR:

- ER-1 REMOVE ALL ELEMENT BASKETS FROM ALL LAYERS BEFORE PERFORMING ROTOR MODIFICATION WORK. ROTOR TO BE PROPERLY GROUNDED BEFORE WELDING TO PREVENT DAMAGE TO BEARINGS AND DRIVES.
- ER-2 ALL ROTOR MODIFICATION WORK SHOULD BE COMPLETED SO THAT EVERY OTHER COMPARTMENT IS WORKED ON ONE AT A TIME, AFTER COMPLETION OF EVERY OTHER COMPARTMENT THE BALANCE OF THE ROTOR CAN BE FIT TACK AND WELDED.
- ER-3 REMOVE THE EXISTING BASKET SUPPORT BARS, FILLER PIECES, GRATING, AND DISCARD. TRIM STAY PLATES TO THE CUT LINE DIMENSION SHOWN IN SECTION "A-A".
- ER-4 INSTALL THE STAY PLATE EXTENSIONS AS SHOWN. (EXTRA CARE SHOULD BE TAKEN TO MAKE SURE THAT THE STAY PLATE EXTENSIONS LINE UP WITH THE CORRESPONDING EXISTING STAY PLATES). MAINTAIN BASKET SUPPORT ELEVATION FLAT WITHIN 1/8".
- ER-5 INSTALL THE INBOARD AND OUTBOARD BASKET SUPPORT BARS REF. #1 & #8 AS SHOWN AND WELD INTO PLACE.
- ER-6 CENTER REF #9 OVER SHELL OPENING AND SEAL WELD AS SHOWN ON THE COVER I.R. (REFER TO SECTION "C-C"). NEW FASTENERS ARE BEING SUPPLIED FOR REF. #9 TO SECURE COVER FOR WELDING IF DESIRED.
- ER-7 USE E-8100 WEATHERING WIRE FOR ALL WELDS.

DETAIL "X"  
(D-4)DETAIL "Z"  
(B-4)

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ALL DIMENSIONS  
ARE IN INCHES  
UNLESS OTHER-  
WISE SPECIFIED



THIRD ANGLE

**ALSTOM**

ALSTOM Power Inc.  
Air Preheater Company  
Wellsville, New York

SUBJECT  
AIR PREHEATER

AP NO.

SIZE 33.5 VI MOD

DR CJC ck DV

APPR. BY

DATE 12/11/03

CLEARFLOW ROTOR  
MODIFICATIONS

CODE

GROUP

SIZE

DWG NO.

REV

ER

0100

D

10031472

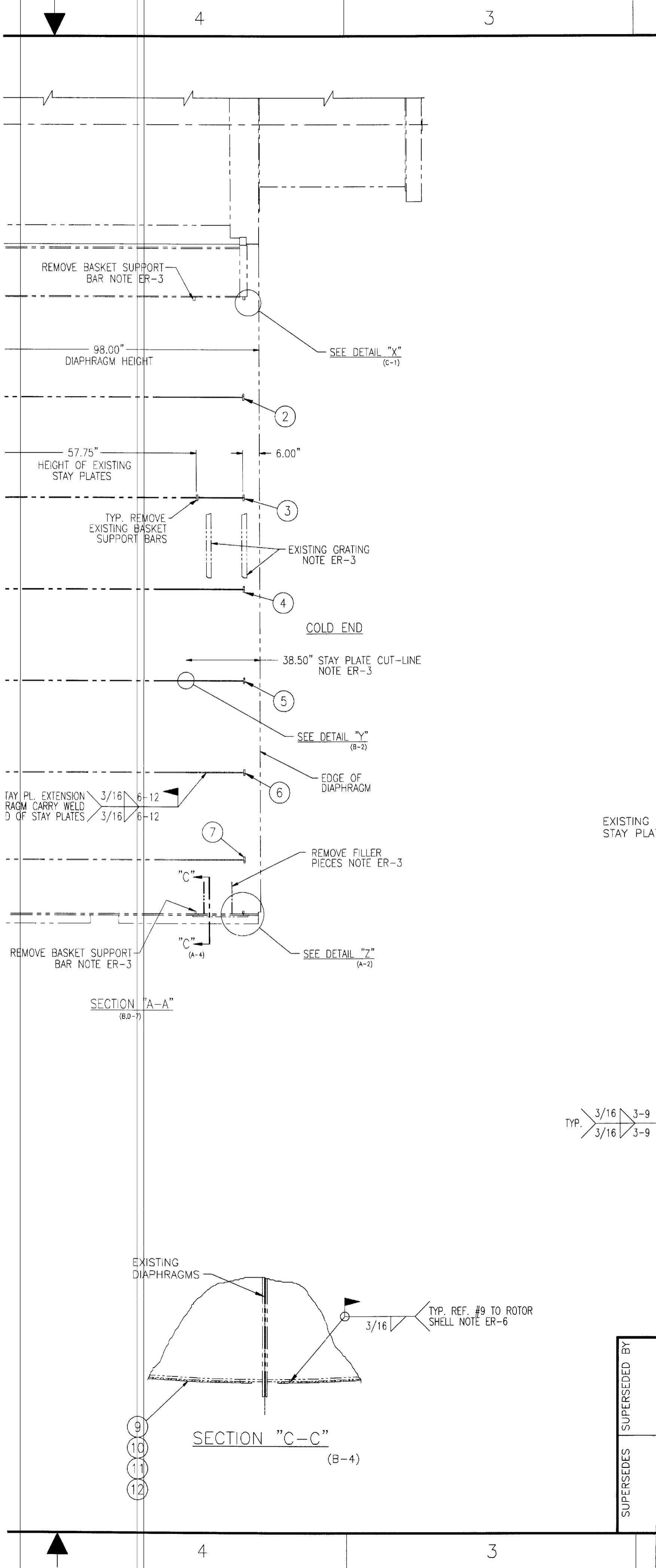
A

SCALE NTS

WT

SHEET

OF

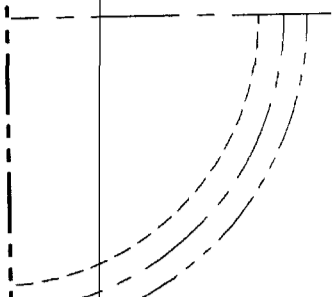


SUPERSEDES BY  
SUPERSEDES

6

5

"A"



DIAPHRAGMS

0.19"

0.31

2

3

4

5

6

8

"B"

(A-6)

308.25" IR

3/16

3/16

BOTH ENDS REF. #8  
TO DIAPHRAGM

END VIEW

STAY PLATE

EXISTING  
DIAPHRAGMS

STAY PLATE

EXISTING  
DIAPHRAGMS

55.75"

88.25"

32.50"

SECTION "B-B"  
(B-6)

BASKET SUPPORT  
ELEVATION

COMPANY  
IN WHOLE  
DRAWINGS  
D THEREON  
COMPANY.

y

REV

A

/03062597]

6

5

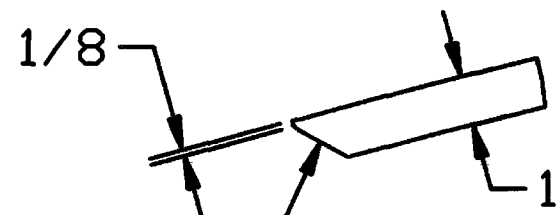
03062713

IP7\_033853

7

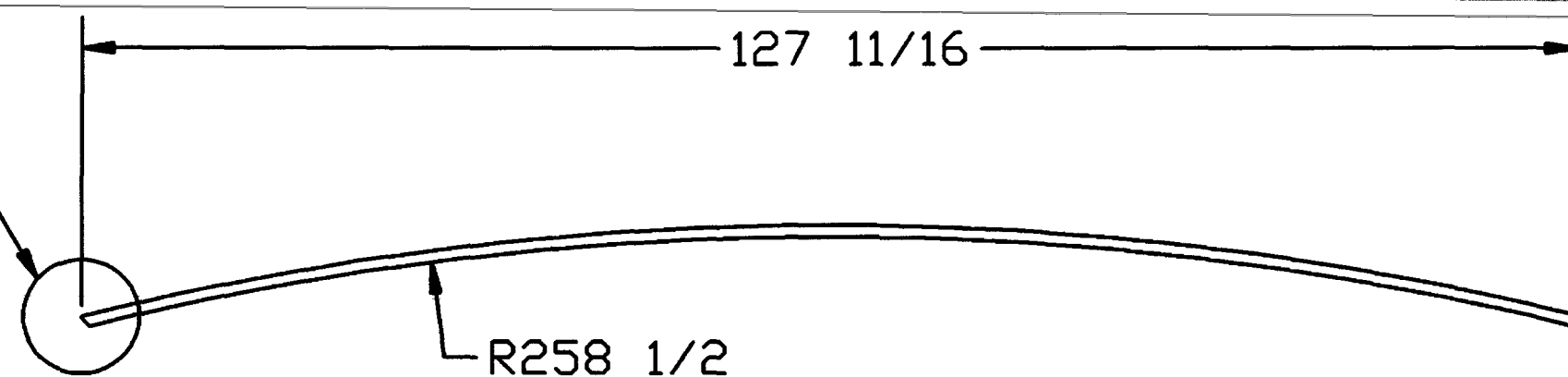
[410]

## ALTERATIONS



DETAIL "Z"  
(1 END ONLY)

DETAIL "Z"

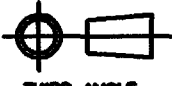


DESCRIPTION: 1 X 8 X 128-3/4 ROLL TO 258-1/2 I.R.  
MATERIAL: 40006

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WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

H				
G				
F				
E				
D				
C				
B				
A	10-31-02	JRL	RAD	CHANGED DIMENSIONS
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

LJUNG/CONT/4399/NEW/0402

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED		<b>ALSTOM</b> <b>ALSTOM Power Inc.</b> <b>Air Preheater Company</b> Wellsville, New York				
	SUBJECT AIR PREHEATER		TENSION RING				
	API NO.						
	SIZE 31 VI						
SUPERSEDES	DR JRL	CK RAD	CODE	GROUP	SIZE	DWG NO.	REV
	APPR. BY			0400	B	10021477	A
	DATE 10-7-02		SCALE NTS	WT		SHEET	OF

BILL OF MATERIAL					
REF.	DRAWING NO.	QTY.	MAT'L.	DESCRIPTION	S.L.
1	D-85512	4		H.E. SEAL GAUGE TUBE ASS'Y (ASS'Y #11)	SL
2	D-49622	1		H.E. GAUGE ROD SETTING BAR (ASS'Y #5)	SL
3	6500160040152	4	6501	6 SCH. #40 PIPE X 9.50 LG.	SL
4	C-2-85510	4	4006	0 38 X 7.25 X 7.25	SL
5	C-3-85510	4	4006	0 25 X 7.25 X 7 25	SL
6	P-1-30534	4	3215	GAUGE WASHER	SL
7	E-26907	4		SEAL GAUGE BUSHING	SL
8	P-2895	4	9904	BLISS JIG SPRING #DS-240 6.00 LG.	SL
9	D-85511	4		BUSHING CAP	SL
10	D-49623	1		H.E. GAUGE ROD ASS'Y (ASS'Y #5)	SL
11	P-20-25413	4	3214	1 25 WASHER	SL
12	P-20-25412	4	3205	1.25 FIN. HEX. NUT	SL
13	P-10-3079	16	3201	0.63 X 1.25 HEX. HD. CAPSCREW	SL
14	P-10-25412	16	3205	0.63 FIN. HEX. NUT	SL

NOTES TO ERECTOR.

ER-1 DRILL FOUR HOLES THRU THE HOT CENTER SECTIONS

ER-2 DRILL AND TAP HOLES INTO SECTOR PLATES AS SHOWN IN SECTION "A-A"

ER-3 CENTER REF #3 ON #4 & WELD AS SHOWN, THEN CENTER THE ASSEMBLY OF REF. #3 & #4 OVER HOLE IN CENTER SECTION AND WELD TO TUB PLATE AS SHOWN IN SECTION "A-A"

ER-4 ASSEMBLY REF #1, #7, #6, #8, #11, #12 AS SHOWN IN SECTIONS "A-A", MAKING SURE REF #1 IS WITHIN 0.13" OF THE SEALING SURFACE

ER-5 AFTER FINAL SETTING OF SECTOR PLATE TIGHTEN REF #12 AND TACKWELD.

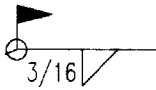
ER-6 INSERT REF #10 INTO REF #7, ADJUST 1/4 TURN AT EACH REVOLUTION OF ROTOR UNTIL ROUNDED END JUST TOUCHES THE RADIAL SEALS

ER-7 REMOVE REF #10 USE REF #9 TO CAP THE TUBE AND INSTALL THE COVER REF. #5 USING REF. #13 & #14

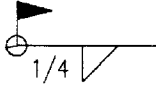
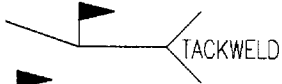
ER-8 CHECK SEAL CLEARANCE USING REF #2 RESPECTIVELY TO DETERMINE THE ACTUAL SEAL SETTINGS

3 & 7

)



14



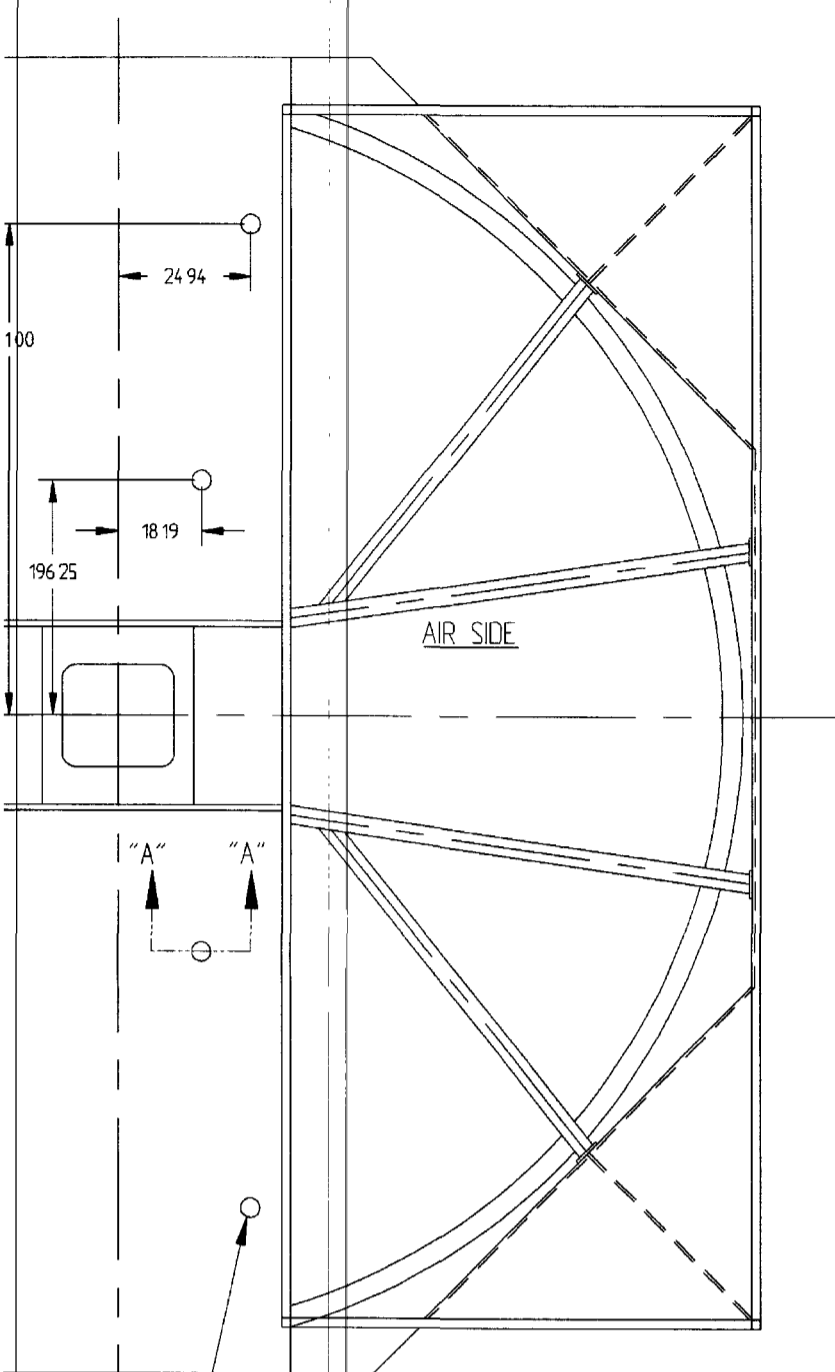
CENTER SECTION  
TUB PLATE

- SECTOR PLATE

SURFACE

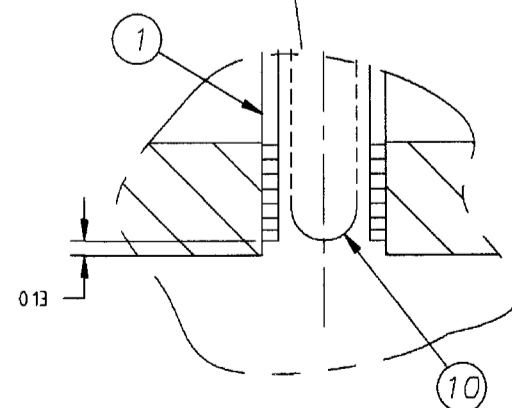
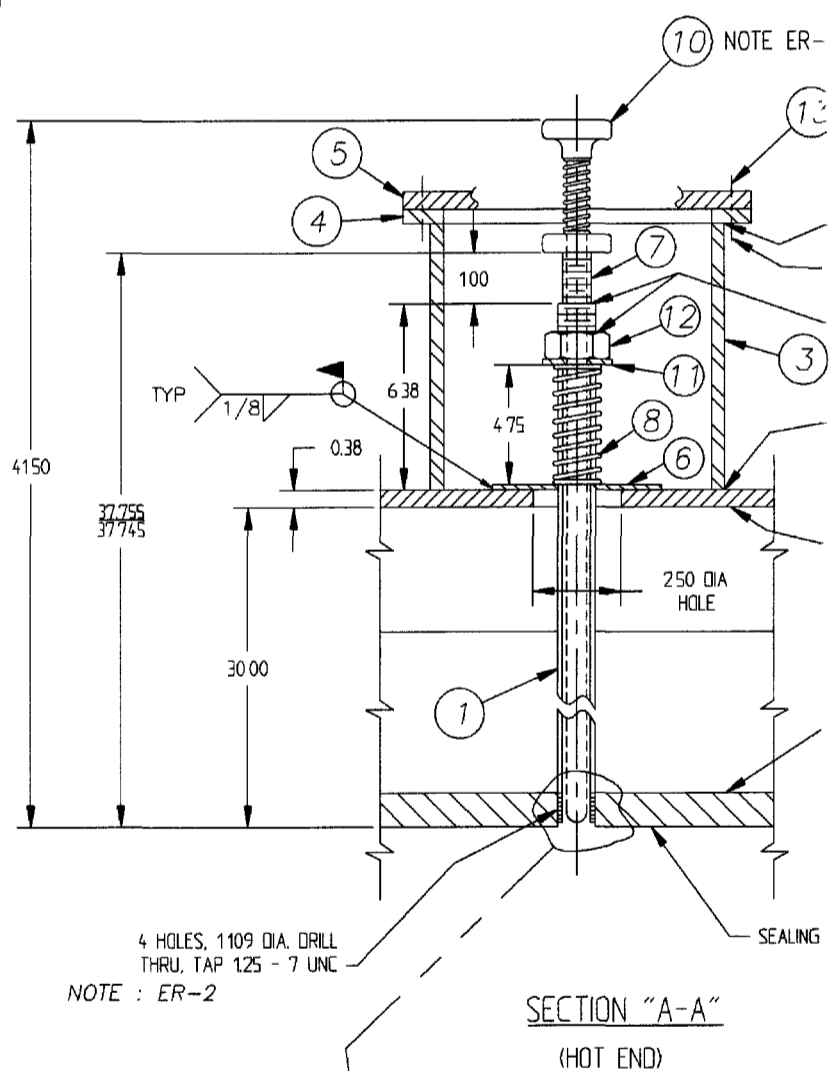
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SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	 THIRD ANGLE	ALSTOM Power Inc. <b>ALSTOM</b> Air Preheater Company Wellsville, New York			
	SUBJECT		HOT END SEAL CLEARANCE GAUGE ASS'Y			
	AIR PREHEATER					
	API NO.					
SUPERSEDES	SIZE	33.5 VI MOD	CODE	GROUP	SIZE	DWG NO.
	DR	WDS	CK	DV	ER	0401
	APPR.	BY	DATE	10-25-04	SCALE	NTS
	WT	SHEET	OF	REV	10041246	

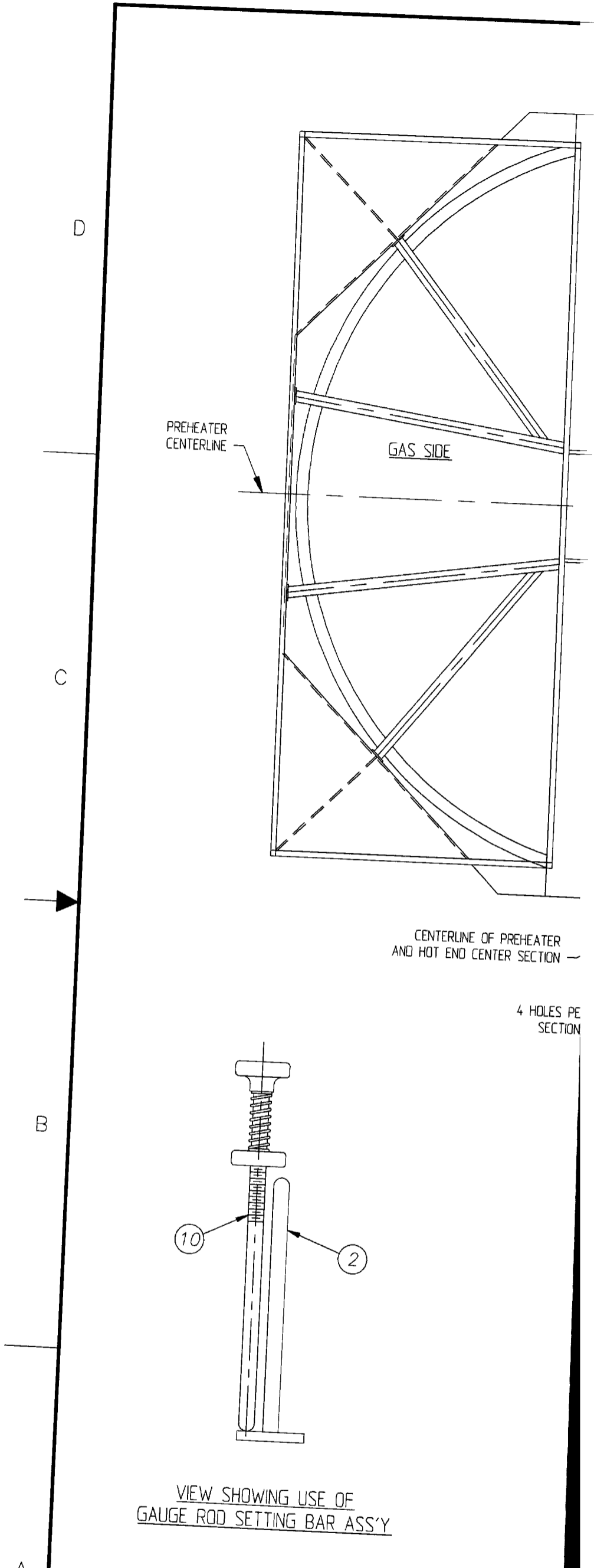


ER CENTER  
N 250 DIA

TOP PLAN VIEW

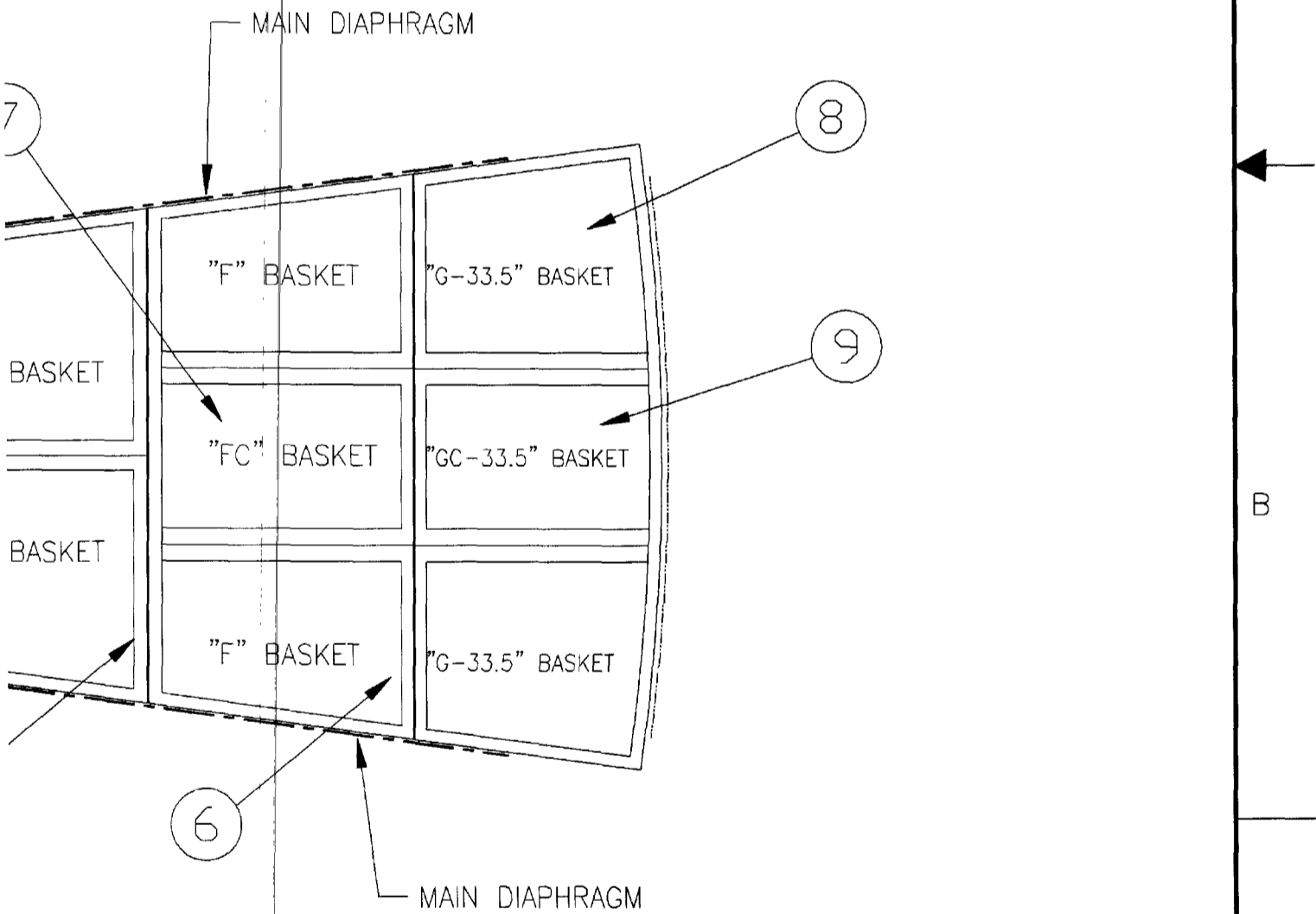


[4098 / 03062713]



H				
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C				
B				
A				
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

BILL OF MATERIAL				
REF. NO.	REQ'D.	MAT'L.	DESCRIPTION	SL
1	24		"A" BASKET SEALING BAR ASSEMBLY	SL
2	24		"B" BASKET SEALING BAR ASSEMBLY	SL
3	48		"C" BASKET SEALING BAR ASSEMBLY	SL
4	48		"D" BASKET SEALING BAR ASSEMBLY	SL
5	48		"E" BASKET SEALING BAR ASSEMBLY	SL
6	48		"F" BASKET SEALING BAR ASSEMBLY	SL
7	24		"FC" BASKET SEALING BAR ASSEMBLY	SL
8	48		"G-33.5"-OUT BSK'T SEALING BAR ASS'Y	SL
9	24		"GC-33.5"-OUT BSK'T SEALING BAR ASS'Y	SL



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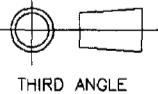
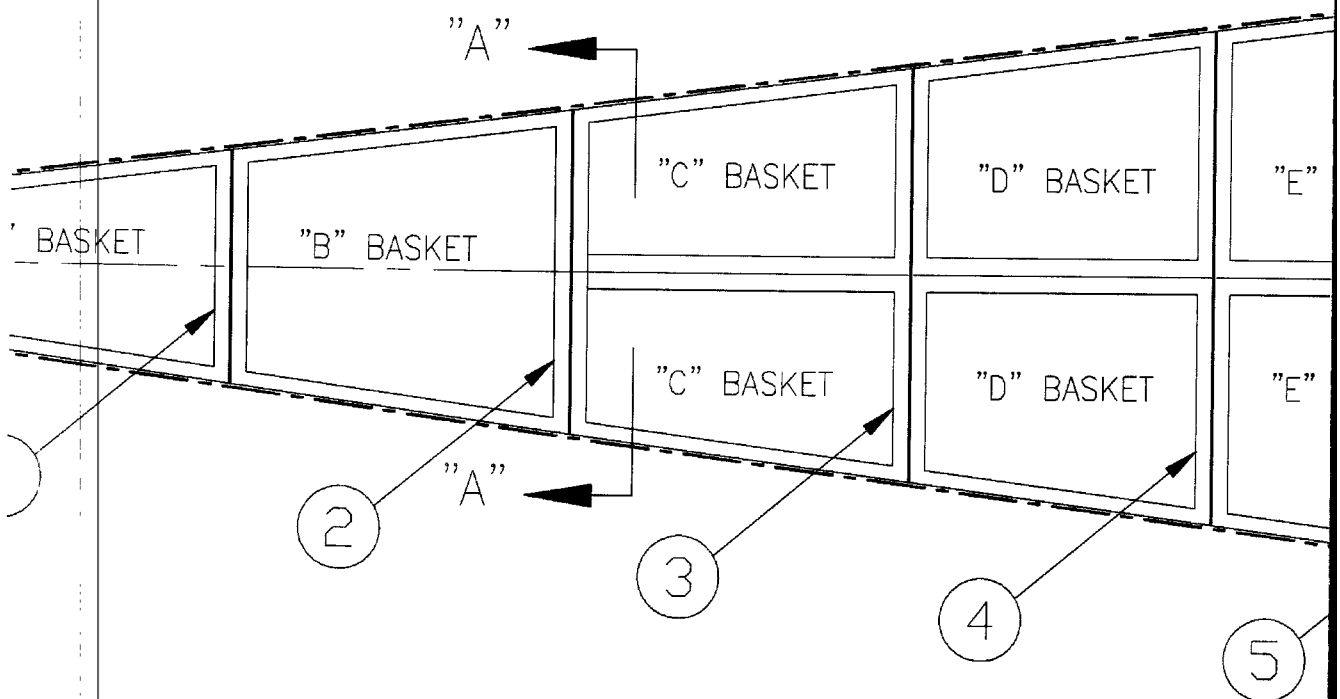
SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	 THIRD ANGLE	<b>ABB</b> ABB AIR PREHEATER, INC. WELLSVILLE, NEW YORK				
	SUBJECT AIR PREHEATER		BASKET SEALING BAR ARRANGEMENT				
	API NO.						
	SIZE 33.5 V-VI						
	SUPERSEDES	DR CU	CK CU	CODE	GROUP	SIZE	DWG NO.
APPR. BY		ER	0204	C	80030675		
DATE 12/11/03		SCALE NTS		WT	SHEET OF		

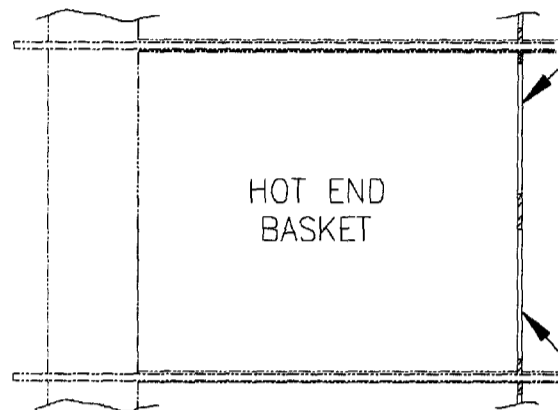
Diagram showing the elevation view of the cold end basket. The main diaphragm is indicated by a line pointing to the top horizontal structure. The cold end basket is labeled. A section line A-A is shown, with a circle containing the number 3 indicating a specific detail or component.



PARTIAL HOT END VIEW

NOTES TO ERECTOR:  
ER-1) AFTER INST  
BETWEEN F.  
ER-2) TRIM SEALIN  
ER-3) INSTALL HOI

D

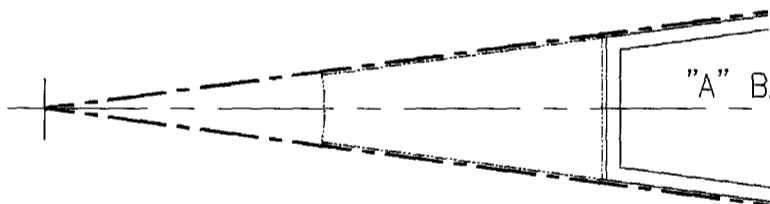


C

SECTION "A"



B



1

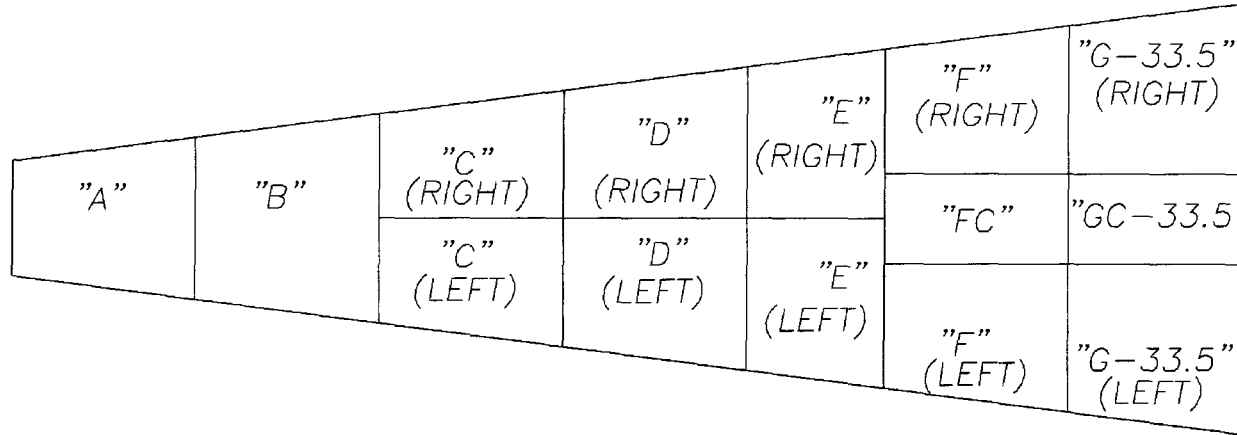
A

H					
G					
F					
E					
D					
C					
B					
A					
MARK	DATE	DR.	CK.	COMMENTS	
ALTERATIONS					

L\STD\BASKET\ARRGT\33.5

# NOTE TO ERECTOR:

ER-1 TO BE USED WITH BASKET SEALS ONLY



TOP PLAN VIEW

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H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	DR.	CK.
ALTERATIONS			

LAYER



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HI  
CE  
CI

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		 THIRD ANGLE		<b>ALSTOM</b> ALSTOM Power Inc. Air Preheater Company Wellsville, New York				
	SUBJECT AIR PREHEATER				BASKET ARRANGEMENT				
	API NO.								
	SIZE 33.5 V/VI				CODE	GROUP	SIZE	DWG NO.	REV
	DR CU      CK CU				ER	0200	A	80030674	
SUPERSEDES	APPR. BY								
	DATE 12/11/03				SCALE NTS		WT	SHEET	OF

IP7\_033862

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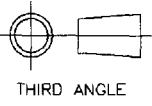
THE USE OF NOTES #1 THROUGH #11 BELOW:  
5, 6, 7, 8, & 11 ARE GENERAL NOTES FOR ALL JOBS.  
REQUIRED ONLY IF SPECIFIED ON THE ERECTION DRAWING.  
& 10 ARE SPECIFICALLY FOR FULL PENETRATION WELDS.

WILL BE 100% VISUALLY EXAMINED AND DOCUMENTED TO ENSURE PRECEDING REQUIREMENTS.  
WILL BE MAGNETIC PARTICLE OR LIQUID PENETRANT EXAMINED IN APPENDIX 6 OR APPENDIX 8 RESPECTIVELY ASME CODE, SECTION VIII, IN ADDITION TO ENSURE THE SURFACES ARE FREE FROM DEFECTS AND WELDED TO ENSURE THEY MEET THE MINIMUM SIZE REQUIREMENT OF THE DRAWING.  
ALL WELDS WILL BE ULTRASONIC EXAMINED IN ACCORDANCE WITH ASME CODE, SECTION VIII, DIVISION 1 LATEST EDITION.  
MAGNETIC PARTICLE AND ULTRASONIC EXAMINATIONS MUST NOT BE DONE UNTIL THE WELD HAS COOLED TO AMBIENT TEMPERATURE.  
ALSTOM COMPANY, INC. AND/OR AUTHORIZED REPRESENTATIVES SHALL HAVE THE RESPONSIBILITY TO INSPECT AND/OR TEST WELDS AND DETERMINE COMPLIANCE WITH REQUIREMENTS.  
WELDING SHALL BE PROGRESSIVE TO ENSURE THAT PROCESS OR PROCEDURE ARE NOT PERPETUATED.  
EACH WELD SHALL BE VISUALLY INSPECTED. PREHEAT SHALL BE MAINTAINED THROUGHOUT THE WELDING CYCLE.  
WELDING PROCEDURE IS TO DEPOSIT HIGH QUALITY, LOW HYDROGEN WELDS IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR AS SPECIFIED.  
THE WELDING IS TO BE CARRIED OUT UNDER THE DIRECTION OF A COMPETENT WELDER AND Q.C. PERSONNEL WHO FULLY UNDERSTAND THE INTENT OF THE WELDING CODES AND WELDING PROCEDURES.  
WELDING OF FULL PENETRATION WELDS IS AN ACCEPTABLE ALTERNATIVE TO BUTT WELDING AND IS TO BE DONE IN ACCORDANCE WITH ASME CODE, SECTION VIII, DIVISION 1 LATEST EDITION ACCEPTANCE CRITERIA PER PARAGRAPH UW.51.  
WELDING SHALL BE PERFORMED AT BOTH HOT AND COLD ENDS WHERE APPLICABLE TO THE STUB DIAPHRAGM. A SPOT ULTRASONIC EXAMINATION SHALL BE DONE TO THE DIAPHRAGM TO STUB DIAPHRAGM JOINT END SECTIONS WHEN FULL PENETRATION WELDS ARE SPECIFIED. IF DEFECTS ARE FOUND, THE ENTIRE LENGTH OF THE WELD WILL BE REWELDED AND RE-EXAMINED BY ULTRASONIC EXAMINATION PER #9 ABOVE.  
PREHEAT SHALL BE A MINIMUM OF 1/8" (3mm) UNLESS OTHERWISE SPECIFIED. IN WELDS REQUIRED ON A DYNAMIC COMPONENT THE MINIMUM SIZE IS 1/4".

WELDING NOTE  
WELDER SHALL BE GROUNDED ANY TIME WELDING TO PREVENT AIR ARCING IS TAKING PLACE TO PREVENT DAMAGE TO BEARINGS AND DRIVES.

MATERIAL NOTE  
ALL AIR PREHEATER PARTS ARE PRODUCED FROM CARBON STEEL (A516) FOR CORROSION RESISTANCE. FOR SPECIFIC LOCATIONS OF WEATHERING STEEL ON AN AIR PREHEATER PLEASE SEE THE SPECIFIC ASSEMBLY DRAWING OR CONTACT YOUR REGIONAL AIR PREHEATER SALES OFFICE, ALSTOM REPRESENTATIVE OR YOUR INSIDE SALES REPRESENTATIVE.

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THIS DRAWING IS TO BE USED IN CONJUNCTION WITH THE AIR PREHEATER DRAWING. SEE THE AIR PREHEATER DRAWING FOR THE LOCATION OF THE WELDING SPECIFICATIONS.	SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED			<b>ALSTOM</b> <b>ALSTOM Power, Inc.</b> <b>Air Preheater Company</b> Wellsville, New York			
		SUBJECT AIR PREHEATER			GENERAL WELDING SPECIFICATIONS			
	API NO.							
	SIZE			CODE	GROUP	SIZE	DWG NO.	REV
	DR RF CK ---			ER	0100	C	65357	P
	APPR. BY							
	DATE 1-30-75			SCALE NTS		WT	SHEET OF	

IN IX LATEST REVISION PER CONTRACT  
PART C SFA-5.1 AND SFA-5.5.)  
CARBON STEEL (LACR) AND LIKE MATERIALS.

F AWS A5.1/ASME SFA-5.1 GRADE E7018  
E8018-W2 LOW HYDROGEN ELECTRODES  
LDING PROCESSES MAY BE USED WITH

LED CONTAINERS. IMMEDIATELY AFTER OPENING  
ORED IN OVENS HELD AT A TEMPERATURE  
L BE REBAKED NO MORE THAN ONCE.

FTER ELECTRODES ARE REMOVED FROM BAKING OR  
SHALL NOT EXCEED FOUR (4) HOURS FOR  
ODES. ELECTRODES EXPOSED TO THE  
RETURNED TO A HOLDING OVEN MAINTAINED  
F FOUR (4) HOURS AT 250 DEGREES F. MINIMUM

REATER THAN THOSE PERMITTED SHALL BE  
THE MANUFACTURER'S INSTRUCTIONS OR THE

IFORMING TO AWS A5.1/ASME SFA-5.1 SHALL BE  
DEES F. AND 800 DEGREES F.

IFORMING TO AWS A5.5/ASME SFA-5.5 SHALL BE  
DEES F AND 800 DEGREES F

TEMPERATURE NOT EXCEEDING ONE HALF (1/2)  
LF (1/2) HOUR PRIOR TO INCREASING THE OVEN  
G TIME SHALL START AFTER THE OVEN REACHES  
ED NO MORE THAN ONCE. ELECTRODES THAT

AL OR VERTICAL UP POSITION UNLESS

PECIFICATIONS:

REHEAT RANGE

3° F. (10° C) MINIMUM

0° F. (66° C) MINIMUM

5° F. (107° C) MINIMUM

OF DIRT, OIL, GREASE AND EXCESSIVE RUST SCALE

ELDING

ELECTRODE WEAVING SHALL BE KEPT TO A MINIMUM  
ST REVISION. TACKWELDS MAY BE INCORPORATED  
BE FREE OF DEFECTS. IF TACKWELDS ARE FOUND  
ASE METAL MUST BE PREHEATED FOR TACKWELDING

CRACKS, PINHOLES, UNDERCUTS AND SHALL BE  
COVER PASSES SHALL BE FREE OF COARSE  
HIGH CROWNS, DEEP RIDGES, UNDERCUTS, ETC.  
VISION

ORE DEPOSITING THE NEXT SUCCESSIVE LAYER OF  
BRUSHED TO PERMIT THOROUGH VISUAL

Y CHIPPING OR GRINDING PRIOR TO DEPOSITING

ACCORDANCE WITH SECTION IX OF THE

① THE FOLLOWING DETAIL  
NOTES 1, 4  
NOTE 2 IS ,  
NOTES 3, 9.

INSPECTION AND TEST-

- Ⓟ 1. ALL FINISHED WELDS  
COMPLIANCE WITH THE
2. ALL FINISHED WELDS  
ACCORDANCE WITH AP  
DIVISION 1 LATEST ED  
DIMENSIONALLY CHECK  
SPECIFIED ON THE DR
3. ALL FULL PENETRATIO  
APPENDIX 12, ASME (
4. LIQUID PENETRANT, M.  
PERFORMED UNTIL THI
5. THE AIR PREHEATER (
- FULL RIGHTS OF ACCE  
WITH THESE REQUIREM
6. NON-DESTRUCTIVE TE  
OPERATOR DEFECTS A
7. THE ROOT PASS OF E  
BE CONTINUOUSLY MA
8. THE INTENT OF THIS  
WELD METAL IN ACCOI  
ASME SECTION IX. TH  
QUALIFIED SUPERVISIO
- THE REFERENCED WEL
9. RADIOGRAPHIC EXAMIN  
TO ULTRASONIC EXAMI  
SECTION VIII, DIVISION
10. ULTRASONIC EXAMINATI  
THE DIAPHRAGM IS JC  
12" (305mm) LONG  
BETWEEN THE INITIAL  
REJECTABLE APPLICATI  
EXAMINED. REJECTABLI
- METHODS PER NOTE #
11. SEAL WELDS ARE TO  
THE CASE OF SEAL W  
3/16" (4mm).

GROUND  
RO  
AND/OR  
DAMAGE

MATERIA  
SOI  
WEATHE  
FOR SF  
ORDER  
CONTAC  
SERVICE  
REPRES

ASSEMBLY TOLERANCE UNLESS NOTED ON DRAWING			FIELD WELD REQUIREMEN UNLESS NOTED ON DRAWING		
STD	0-24 (0-610mm)	±0.13(3mm)	CONVERSIONS		FILLER METAL - E7018 UNLESS OTHERWISE SPECIFIED  ALL WELDS TO CONFORMANCE AWS D1.1 STRU WELDING CODE EQUIVALENT
	24-96(610-2438mm)	±0.19(5mm)	INCH	MM	
	OVER 96(2438mm)	±0.25(6mm)	1/8	3	
			3/16	4	
			1/4	6	
			5/16	8	
			3/8	10	
			1/2	12	
ANGLES		±0.5°			

GENERAL WELDING SPECIFICATIONS:

ALL WELDING SHALL BE PER AWS D1.1 AND/OR ASME SECTIC REQUIREMENTS. (REFERENCE AWS A5.1, AWS A5.5, ASME SECTIO THIS SPECIFICATION IS INTENDED FOR A36, A-588, WEATHERING (

FILLER METAL-

THE FILLER METAL SHALL CONFORM TO THE REQUIREMENTS C LOW HYDROGEN ELECTRODES OR AWS A5.5/ASME SFA-5.5 GRADE BASED ON CONTRACT REQUIREMENTS. OTHER LOW HYDROGEN WE WRITTEN APPROVAL FROM The Air Preheater Company, Inc.

FILLER METAL STORAGE-

ALL ELECTRODES SHALL BE PURCHASED IN HERMETICALLY SE THE HERMETICALLY SEALED CONTAINER, ELECTRODES SHALL BE S OF AT LEAST 250 DEGREES FAHRENHEIT (F.). ELECTRODES SHAL ELECTRODES THAT HAVE BEEN WET SHALL NOT BE USED.

APPROVED ATMOSPHERIC TIME PERIODS-

AFTER HERMETICALLY SEALED CONTAINERS ARE OPENED OR A STORAGE OVENS, THE ELECTRODE EXPOSURE TO THE ATMOSPHER E7018 ELECTRODES OR TWO (2) HOURS FOR E8018-W2 ELECTRO ATMOSPHERE FOR PERIODS LESS THAN THOSE PERMITTED MAY BE AT 250 DEGREES F. MINIMUM; AFTER A MINIMUM HOLD PERIOD O THE ELECTRODES MAY BE REISSUED.

BAKING ELECTRODES-

ELECTRODES EXPOSED TO THE ATMOSPHERE FOR PERIODS GR DISPOSED OF OR BAKED ACCORDING TO THE MORE STRINGENT O FOLLOWING:

- 1. ALL ELECTRODES HAVING LOW HYDROGEN COVERINGS CO BAKED FOR AT LEAST TWO (2) HOURS BETWEEN 500 DE
- 2 ALL ELECTRODES HAVING LOW HYDROGEN COVERINGS CO BAKED FOR AT LEAST ONE (1) HOUR BETWEEN 700 DEG

ALL ELECTRODES SHALL BE PLACED IN A SUITABLE OVEN AT A T OF THE FINAL BAKING TEMPERATURE FOR A MINIMUM OF ONE HA TEMPERATURE TO THE FINAL BAKING TEMPERATURE. FINAL BAKIN THE FINAL BAKING TEMPERATURE. ELECTRODES SHALL BE REBAK HAVE BEEN WET SHALL BE DISCARDED.

POSITION-

ALL WELDING SHALL BE PERFORMED IN THE FLAT, HORIZONTAL INSTRUCTIONS ON DRAWINGS STATE OTHERWISE.

PREHEAT-

THE FOLLOWING SCHEDULE SHOWS RECOMMENDED PREHEAT S  
BASE METAL THICKNESS  
0" TO 1.50" INCLUSIVE (0mm TO 38mm) 5  
1 50" TO 2.50" INCLUSIVE (38mm TO 64mm) 15  
OVER 2.50" (64mm) 22  
THICKEST SECTION OF BASE METAL TO BE JOINED.

PREPARATION OF BASE METAL-

THE SURFACES TO BE JOINED BY WELDING SHALL BE FREE OR OTHER FOREIGN MATTER.

ELECTRICAL CHARACTERISTICS-

DIRECT CURRENT REVERSE POLARITY SHALL BE USED FOR W

PROCEDURE-

ALL WELDS SHALL BE MADE AS SPECIFIED ON DRAWINGS. E AND SHALL NOT EXCEED THE REQUIREMENTS OF AWS D1.1 LATE IN THE WELD IF THEY ARE VISUALLY INSPECTED AND FOUND TO UNACCEPTABLE THEY ARE TO BE REMOVED BEFORE WELDING. B PER PREHEAT SCHEDULE.

WORKMANSHIP AND VISUAL QUALITY-

EACH LAYER OF WELDING SHALL BE SMOOTH AND FREE OF COMPLETELY FUSED TO ADJACENT WELD BEADS OR BASE METAL. RIPPLES, IRREGULAR SURFACES, NON-UNIFORM BEAD PATTERNS, AND CONFORM TO THE REQUIREMENTS OF AWS D1.1 LATEST REV

CLEANING-

ALL SLAG SHALL BE REMOVED FROM EACH WELD BEAD BEFO WELD METAL. FINISHED WELDS MUST BE DE-SLAGGED AND WIRI INSPECTION AND NON-DESTRUCTIVE EXAMINATION.

DEFECTS-

CRACKS, PINHOLES OR POOR TIE-INS SHALL BE REMOVED B SUBSEQUENT LAYERS OF WELD METAL.

QUALIFICATIONS-

WELDING PROCEDURES AND WELDERS MUST BE QUALIFIED IN ASME BOILER AND PRESSURE VESSEL CODE OR AWS D1.1.

U				
T				
S				
R				
Q				
P	10/09/01	JRC	AGM	MODIFIED INSPECTION NOTE #1
O	06/21/00	KMF	ACS	ADDED CLARIFICATION FOR SPECIFIC NOTES
N	06/10/99	GP	KMF	REDRAWN FROM "D" SIZE & MODIFIED NOTES
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

## BILL OF MATERIAL

DRAWING NO.	REQ D.	MAT'L	DESCR PT ON	SL	LOFT
P-18-25404	TAB"E"	3201	5/8" x 2-1/4" HEX. HD. CAPSCREW	SL	
P-14-25404	144	3201	5/8" x 1-3/4" HEX. HD. CAPSCREW	SL	
P-10-25412	TAB"F"	3205	5/8" HEX NUT	SL	
P-10-25413	TAB"G"	3214	5/8" WASHER	SL	
D-69637	4		ROTOR POST SEAL (HE)	SL	
D-69009	4		ROTOR POST SEAL (CE)	SL	
C-TAB"L"-69636	24		INBOARD RADIAL SEAL LEAF (HE)	SL	
C-TAB"L"-67790	24		INBOARD RADIAL SEAL LEAF (CE)	SL	
C-67511	96		OUTBOARD RADIAL SEAL LEAF (HE)	SL	
C-1-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-75389	24		OUTBOARD SEAL TAB (HE)	SL	
C-2-67953	24		OUTBOARD SEAL TAB (CE)	SL	
D-TAB"L"-67795	24		INBOARD HOLDING STRIP (HE)	SL	
D-TAB"L"-78083	24		INBOARD HOLDING STRIP (CE)	SL	
D-2-67524	72		HOLDING STRIP (HE)	SL	
D-2-78084	72		HOLDING STRIP (CE)	SL	
H-17-78077	1	4011	3/8" x 4" x 60"	SL	
E-67521	192		SPACER BAR	SL	
C-67517	96		OUTBOARD DIAPH. SEAL (HE)	SL	
D-77033	96		OUTBOARD DIAPH. SEAL (CE)	SL	
E-67800	24		"T" BAR TAB	SL	
E-67540	24		"T" BAR TAB	SL	
B-66281	24		"T" BAR ASS'Y. ASS'Y*(TAB"L")	SL	
E-65558	48		CLIP	SL	
E-1-67526	24		END PLATE	SL	
C-52965	1/CONT		RADIAL SEAL STRAIGHT EDGE ASS'Y, ASS'Y*(TAB"M")	SL	
H-27-78077	1	5102	3/8" x 4" x 60"	SL	
H-28-78077	24	4211	1/2 GA. x 1-1/16" x 1-5/8"	SL	
C-2-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-3-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-4-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
H-32-78077	1	5102	1/4" x 4" x 60"	SL	
H-33-78077	1	5102	1/2" x 4" x 60"	SL	
E-77345	24		"T" BAR TAB	SL	
E-77351	24		"T" BAR TAB	SL	
B-77352	24		"T" BAR ASS'Y. # TAB "L"	SL	
E-1-68706	24		END PLATE	SL	
H-38-78077	1	4011	1/4" x 4" x 60"	SL	
H-39-78077	1	4011	1/2" x 4" x 60"	SL	
P-18-31500	TAB"E"	3201	5/8" x 2-1/4" HEX. HD. BOLT	SL	
P-14-31500	144	3201	5/8" x 1-3/4" HEX. HD. CAPSCREW	SL	
P-10-1420	TAB"F"	3205	5/8" HEX NUT	SL	
P-6-1289	TAB"G"	3221	5/8" LOW ALLOY-FLAT WASHER	SL	
D-1-78084	24		HOLDING STRIP (CE)	SL	
D-1-67524	24		HOLDING STRIP (HE)	SL	

## THE FOLLOWING TO BE USED FOR CLOCKWISE ROTATION

D-TAB"L"-67809	24		INBOARD DIAPH. SEAL H.E. (AS SHOWN)	SL	
D-TAB"L"-67811	24		INBOARD DIAPH. SEAL C.E. (AS SHOWN)	SL	

## THE FOLLOWING TO BE USED FOR COUNTER-CLOCKWISE ROTATION

D-TAB"L"-67810	24		INBOARD DIAPH. SEAL H.E. (OPP. HAND)	SL	
D-TAB"L"-67812	24		INBOARD DIAPH. SEAL C.E. (OPP. HAND)	SL	

## TO FRETOR:

ALL BOLTS, NUTS AND WASHERS TO BE INSTALLED EXACTLY AS SHOWN. FOLLOW INSTRUCTIONS ON "SEAL INSTALLATION AND SETTING DRAWING", GROUP #2106. ON HOT END DETERMINE HIGHEST DIAPHRAGM. MEASURE DISTANCE FROM CENTER OF OUTBOARD RADIAL SEAL BOLT HOLE TO MACHINED SURFACE OF SECTOR PLATE OR TO SEAL STRAIGHT EDGE. SUBTRACT 1" FROM THIS DIM. AND SET ALL HOT END "T" BARS SUPPORT ANGLES TO THIS DIM. FROM COLD END OF SAME DIAPHRAGM. MEASURE DISTANCE FROM CENTER OF OUTBOARD RADIAL SEAL BOLT HOLE TO MACHINED SURFACE OF SECTOR PLATE OR TO SEAL STRAIGHT EDGE. SUBTRACT 0" FROM THIS DIM. & SET SUPPORT ANGLES TO THIS DIM.. TOTAL VARIATION BETWEEN CONNECTING PL TO HOUSING SPLIT & THE "T" BAR SUPPORT ANGLE NOT TO EXCEED 1/4".

AFTER SUPPORT ANGLES ARE SET & WELDED IN PLACE, INSTALL ALL OF SPACERS (CUT TO FIT FROM REF. #17, 27, 32, 33, 38 & 39) BEFORE INSTALLING ROTOR "T" BARS.

INSTALL "T" BARS, REF. #23 & 36 WITH ENDS LOCATED ON CENTER LINES OF MODULES TO THE RADIUS SHOWN NOT EXCEEDING A TOTAL VARIATION OF 1/8". BOLT "T" BAR TO SUPPORT ANGLES. INSTALL CLIPS, REF. #24 & WELD AS SHOWN IN VIEW "L-L".

INSTALL ROTOR POST SEALS, REF. #5 & 6 TO CLEARANCE DIMENSION SHOWN & WELD AS SHOWN IN VIEW "A-A".

## RECOMMENDED PROCEDURE FOR INSTALLING RADIAL SEALS:

7.1 STARTING AT OUTBOARD ENDS, LOCATE DIAPH. SPACER WITH SPACER HOLES CENTERED IN DIAPH.. TACKWELD TO ONE DIAPH. ONLY AS SHOWN. AT OUTBOARD AND INBOARD BOLT HOLES INSET BOLTS, REF. #1 & 40, WITH WASHER REF. #4 & 43, & DIAPH. SEAL, REF. #19 & #20, ON BOLT. INSTALL RADIAL SEAL LEAF SECTION FOLLOWED BY RADIAL SEAL TAB & HOLDING STRIP. BOLT ALL THE COMPONENTS TOGETHER WITH HEX NUTS, REF. #3 & 42, WITHOUT TIGHTENING. INSTALL REF. #1, #3, #4, #40, #42 & #43 IN THEIR PROPER LOCATION FOR THE REMAINING BOLT HOLES IN THE SECTION. DO NOT TIGHTEN. REPEAT THIS PROCEDURE FOR THE REMAINING SEAL LEAF SECTIONS. TRIM INBOARD SEALS TO FIT IF NECESSARY.

7.2 AFTER SEALS ARE INSTALLED AND SET TO STRAIGHT EDGE, TIGHTEN BOLTS.


7.3 LOCATE REF. #25 & #37 AND WELD TO REF. #17, 19, 20, 27, 32, 33, 38 & 39. LOCATE REF. #28 AND WELD AS SHOWN.

7.4 LOCATE REF. #21, 22, 34 & 35 AND WELD TO "T" BAR ONLY.

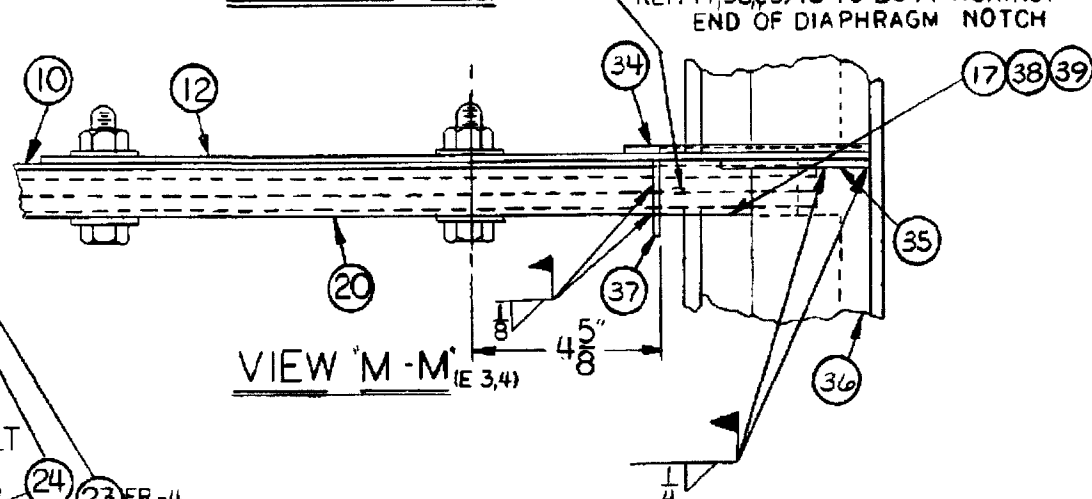
SEAL WELD END OF INBOARD RADIAL SEAL, REF. #7 & #8 & INBOARD DIAPHRAGM SEAL, REF. #52, 53, 62 & 63 (ACROSS TOP & DOWN SIDE) TO POST SEAL AS SHOWN.

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LAS. COLD END ~ DEF. SECT PL's.

SUPERSEDED BY	Subject	AIR PREHEATER		 <b>AIR PREHEATER</b> GE AIR PREHEATER WELLSVILLE, NEW YORK				
	Model / Argt	MOD						
	Size, Type Series	32-1/2 - 33+1/2 VI						
	Des.	Ch.						
SUPERSEDES	Dr. KAT	Ch.	DV	RADIAL SEAL ASS'Y. (5/16" DIAPH.)				
	Tr.	Ch.						
	Material							
	Stk. No.							
DATE 3-16-83		SCALE	NTS	CODES	DRAWING NUMBER			
				80509	GROUP	SIZE	NUMBER	ISSUE
				ER	0103	H	78077	A
					WT.	SHEET OF		

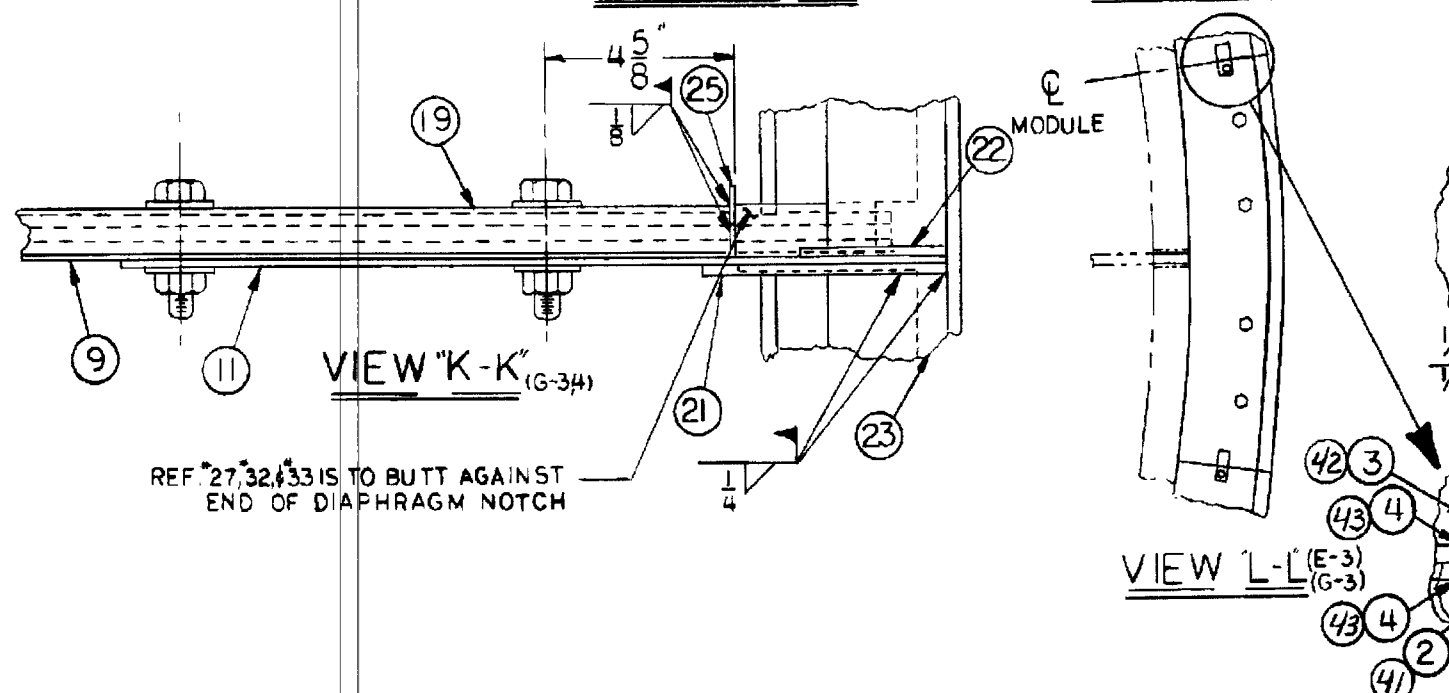
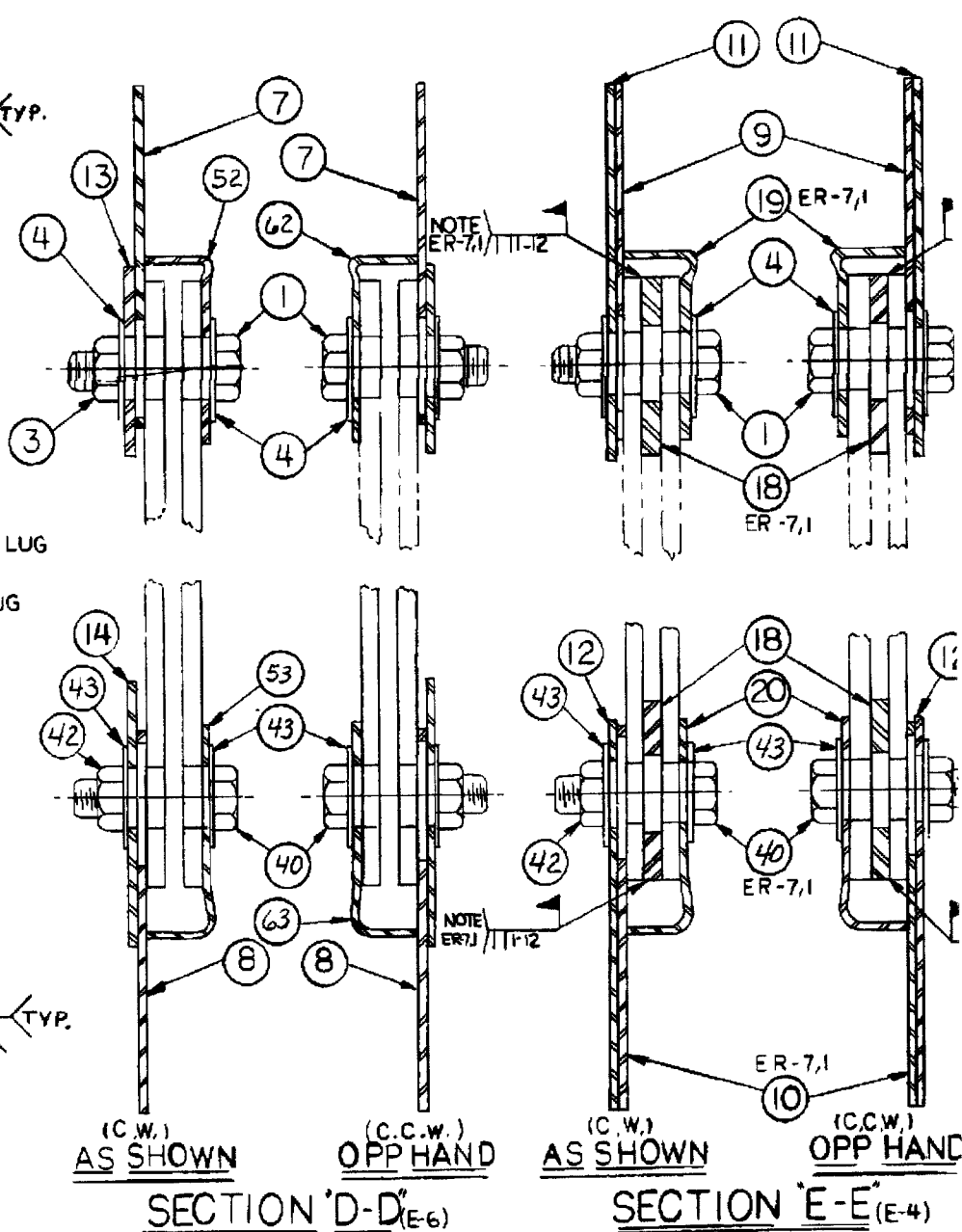
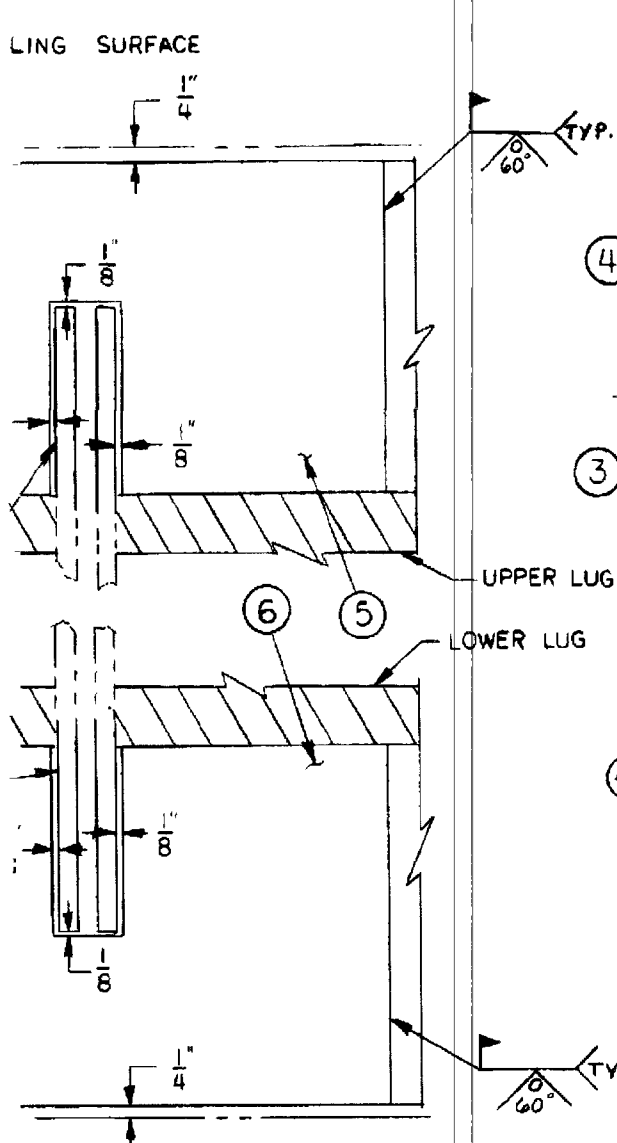
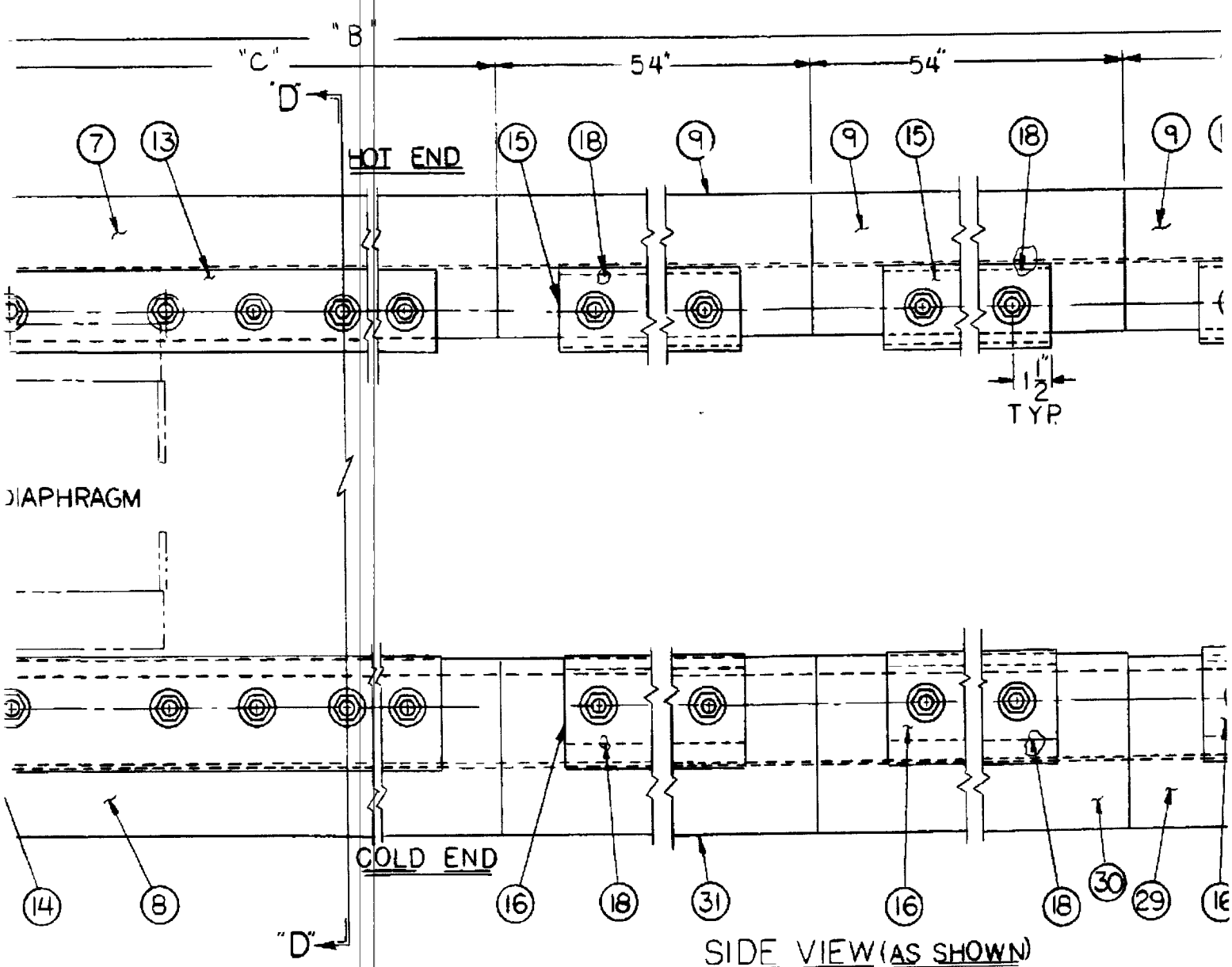
62	
63	



ER-

**IP7 033867**

TAB. "L"	TAB. "M"	ASS'Y. NO.	ASS'Y. REQ'D.
1	1	1	
2	2	2	
3	3	3	



TABULATION

ASS'Y. REQ'D.	ASS'Y. NO.	HEATER SIZE	DIM. "A"	DIM. "B"	DIM. "C"	TAB. "E"	TAB. "F"	TAB. "G"
	1	32-1/2	286-1/2"	246-1/4"	23-1/4"	648	792	1584
	2	33	300-1/2"	260-1/4"	37-1/4"	696	840	1680
X	3	33-1/2	314-1/2"	274-1/4"	51-1/4"	720	864	1728

H

G

F

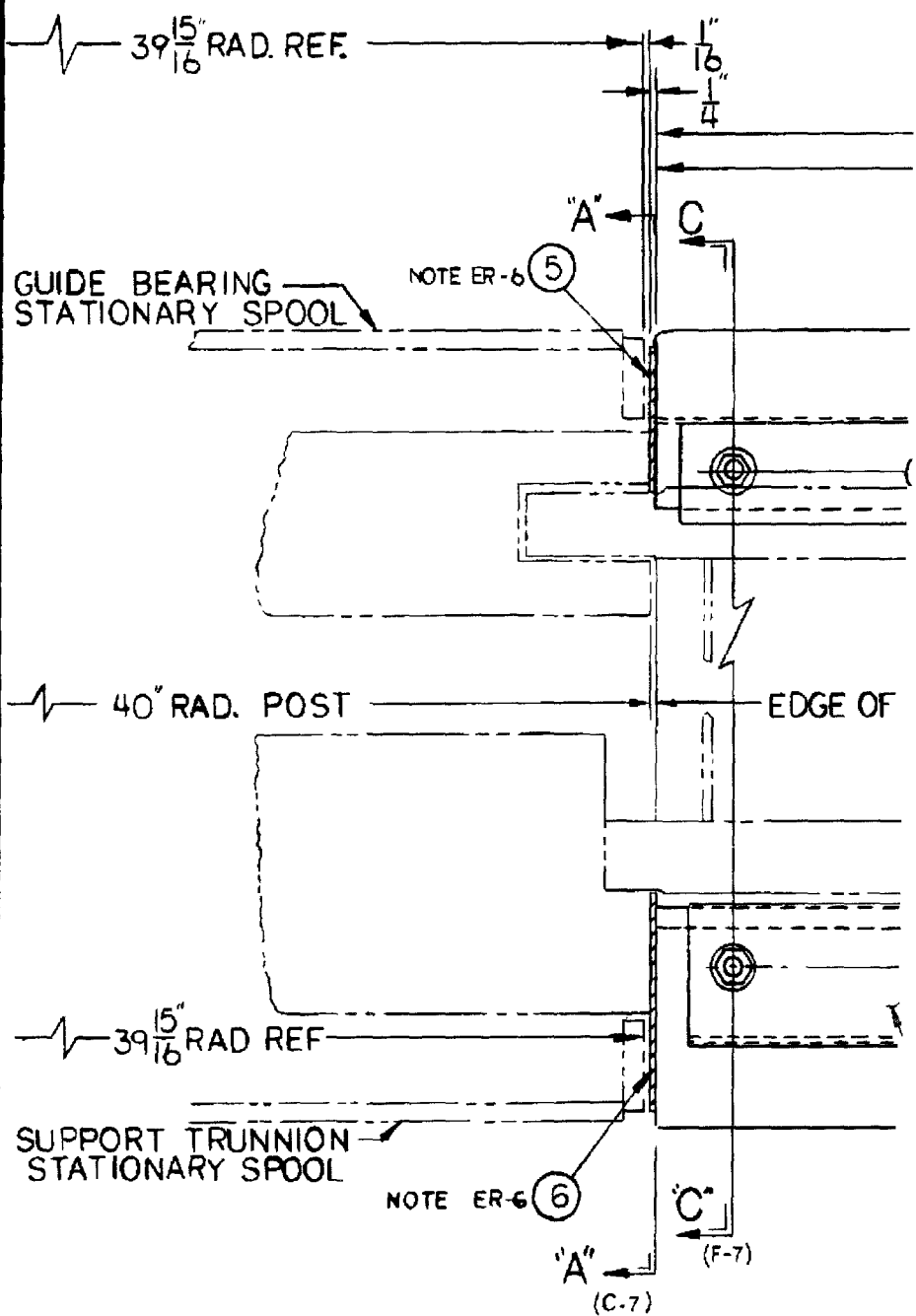
E

D

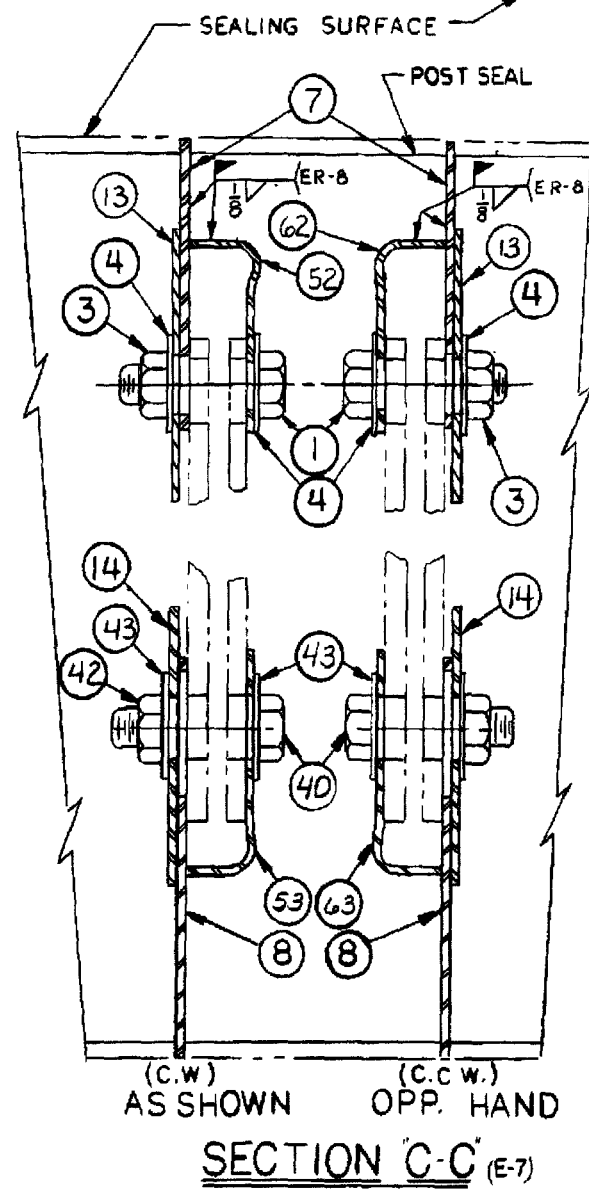
C

B

A



SEAL WELD TO DIAPH. &  
LUG ONLY. TYP.  
AWS 4.10.02

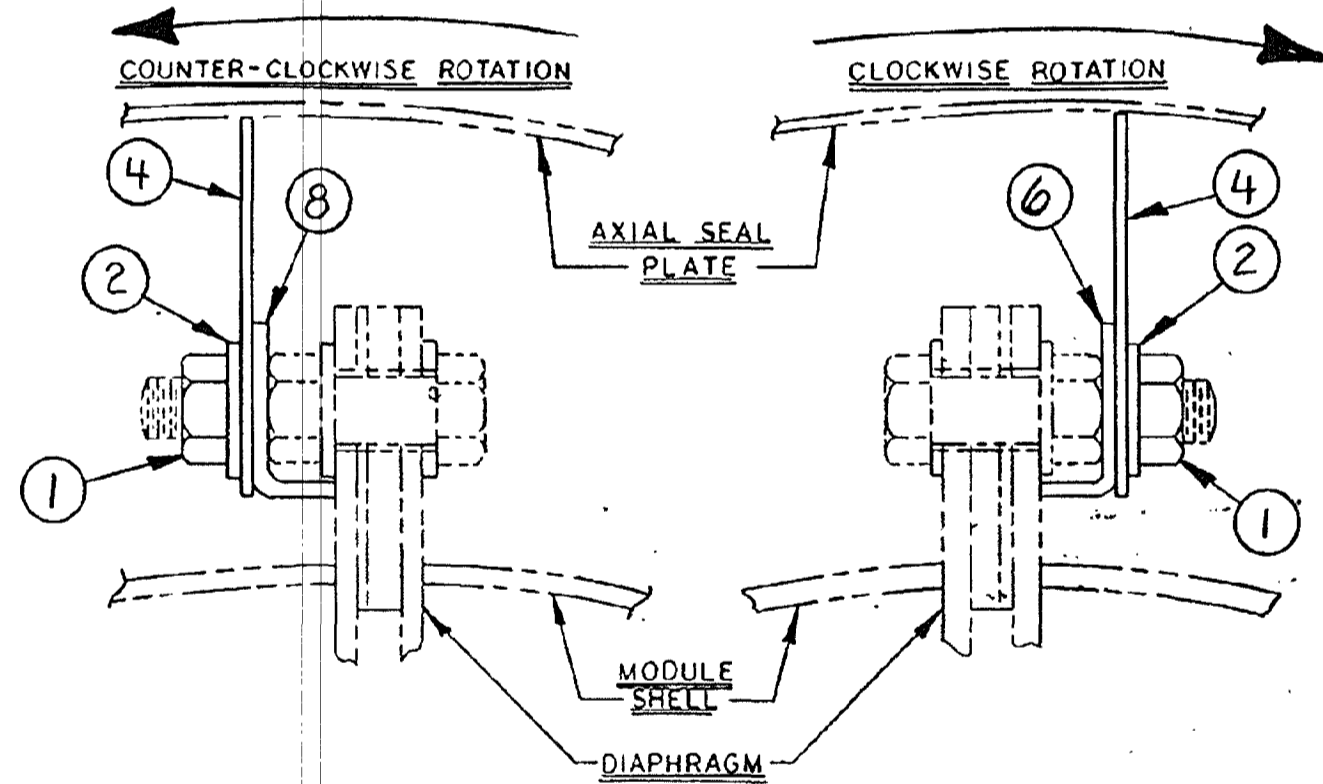


J			
I			
H			
G			
F			
E			
D			
C			
B			
A	3-12-84	RMS	RAD
MARK	DATE	ALT.	CKD.
ALTERATIONS			

BRUNING 40 231 51260

BILL OF MATERIAL						
REF. NO.	PART CODE NO.	DRAWING NO.	REQ'D.	MAT'L.	DESCRIPTION	LOFT
1	32050	P-12-25412	"C"	3205	3/4" FIN. HEX. NUT	SL
2	32140	P-12-25413	"C"	3214	3/4" WASHER	SL
3		D-E-78076	24		AXIAL SEAL LEAF (COLD END)	SL
4		D-F-78076	24		AXIAL SEAL LEAF (HOT END)	SL
THE FOLLOWING TO BE FOR CLOCKWISE ROTATION						
5		D-G-76118	24		FORMED HOLDING STRIP (COLD END)	SL
6		D-H-76117	24		FORMED HOLDING STRIP (HOT END)	SL
THE FOLLOWING TO BE FOR COUNTER-CLOCKWISE ROTATION						
7		D-G-76117	24		FORMED HOLDING STRIP (COLD END)	SL
8		D-H-76118	24		FORMED HOLDING STRIP (HOT END)	SL

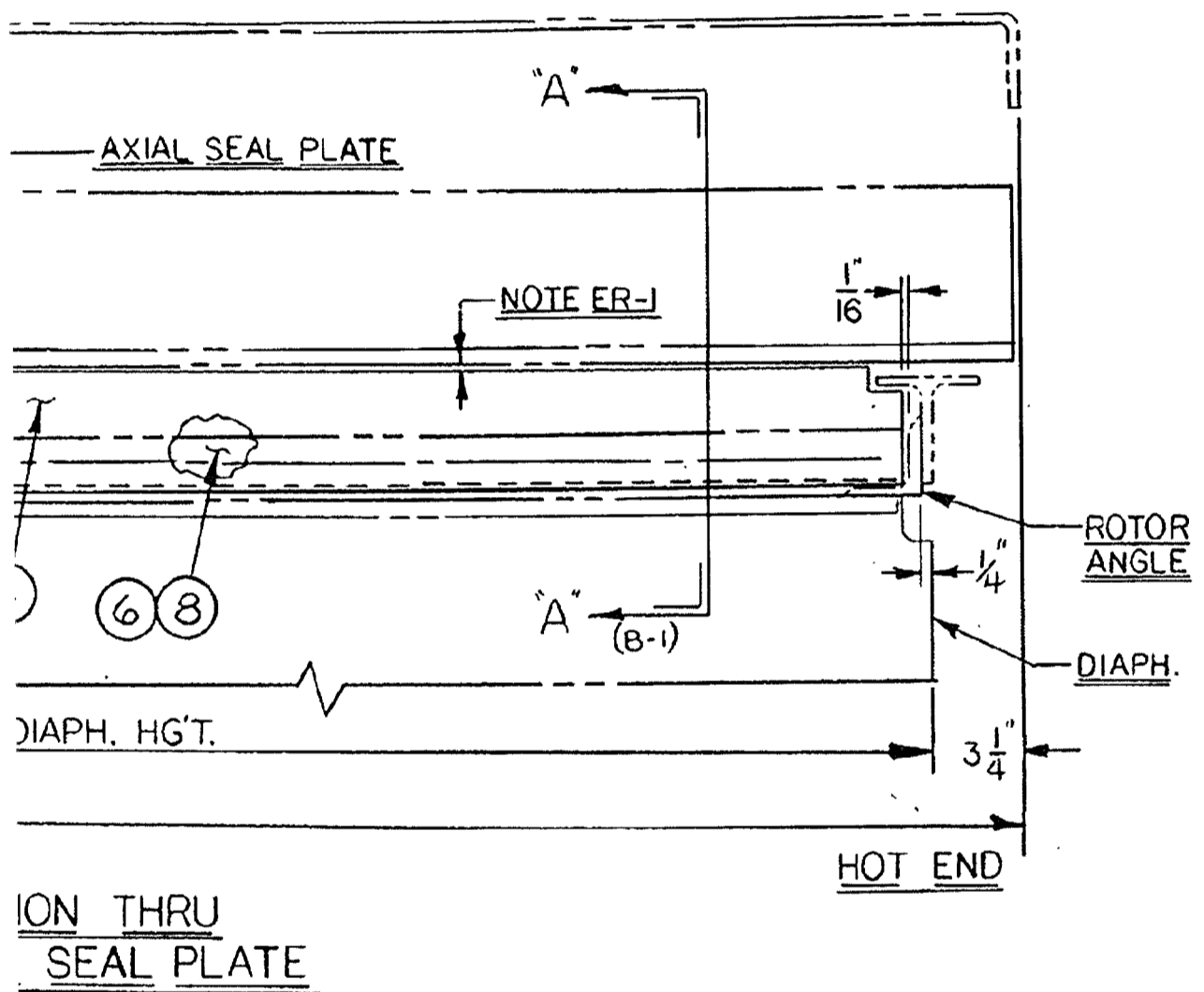
NOTES TO ERECTOR:  
ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106.  
ER-2 NOTCH FORMED HOLDING STRIP TO FIT AT ASSEMBLY.



SECTION "A-A" (B-3)  
AS VIEWED FROM HOT END

2 LAYER SIDE REMOVAL - DEF. SECTOR PL.

AND IT TO FOR HOUT	SUPERSEDED BY	Subject <b>AIR PREHEATER</b>		<b>CE PROCESS EQUIPMENT</b> CE AIR PREHEATER WELLSVILLE, NEW YORK	
		Model/ Arrg't <b>MOD.</b>			
		Size, Type Series: <b>32 1/2 - 34 VI.</b>			
		Des.	Ch.		
		Dr. <b>KAT</b>	Ch. <b>DV</b>		
	SUPERSEDES	Tr.	Ch.	<b>AXIAL SEAL ASSEMBLY</b> 9"-CLEAR PIN LENGTH	
		Material			
		Stk. No.			
		DATE <b>3-15-83</b> SCALE <b>NTS</b>			
		CODES <b>ER 80100 (M)</b>			
DRAWING NUMBER		GROUP <b>0504</b>	SIZE <b>C</b>	NUMBER <b>78075</b>	ISSUE
WT.					

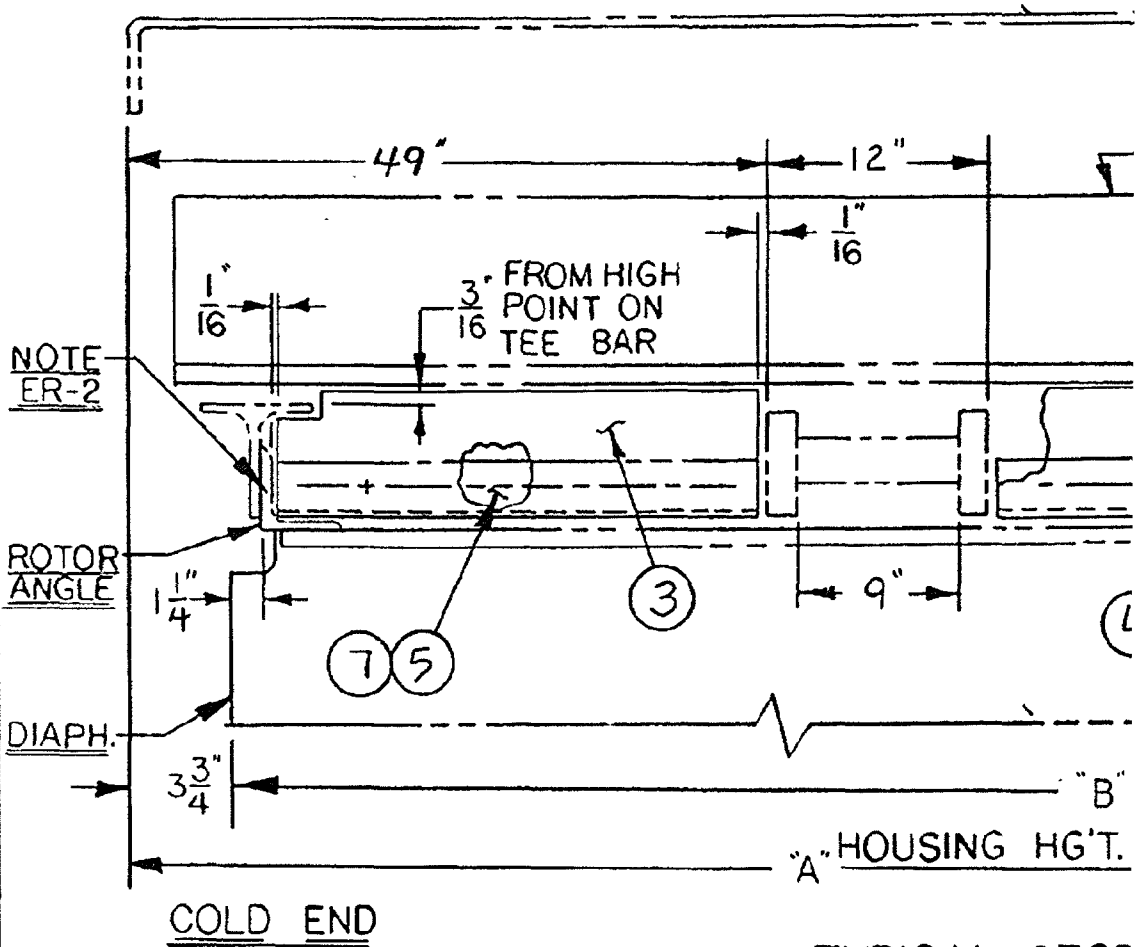


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T A B U L A T I O N										
ASS'Y. REQ'D.	ASS'Y. NO.	TAB "A"	TAB "B"	TAB "C"	TAB "E"	TAB "F"	TAB "G"	TAB "H"	APPROX. WGT.	ASS'Y. REQ'D.
	1	105"	98"	336	1	2	7	8		
	2									
	3									

D

C



B

A

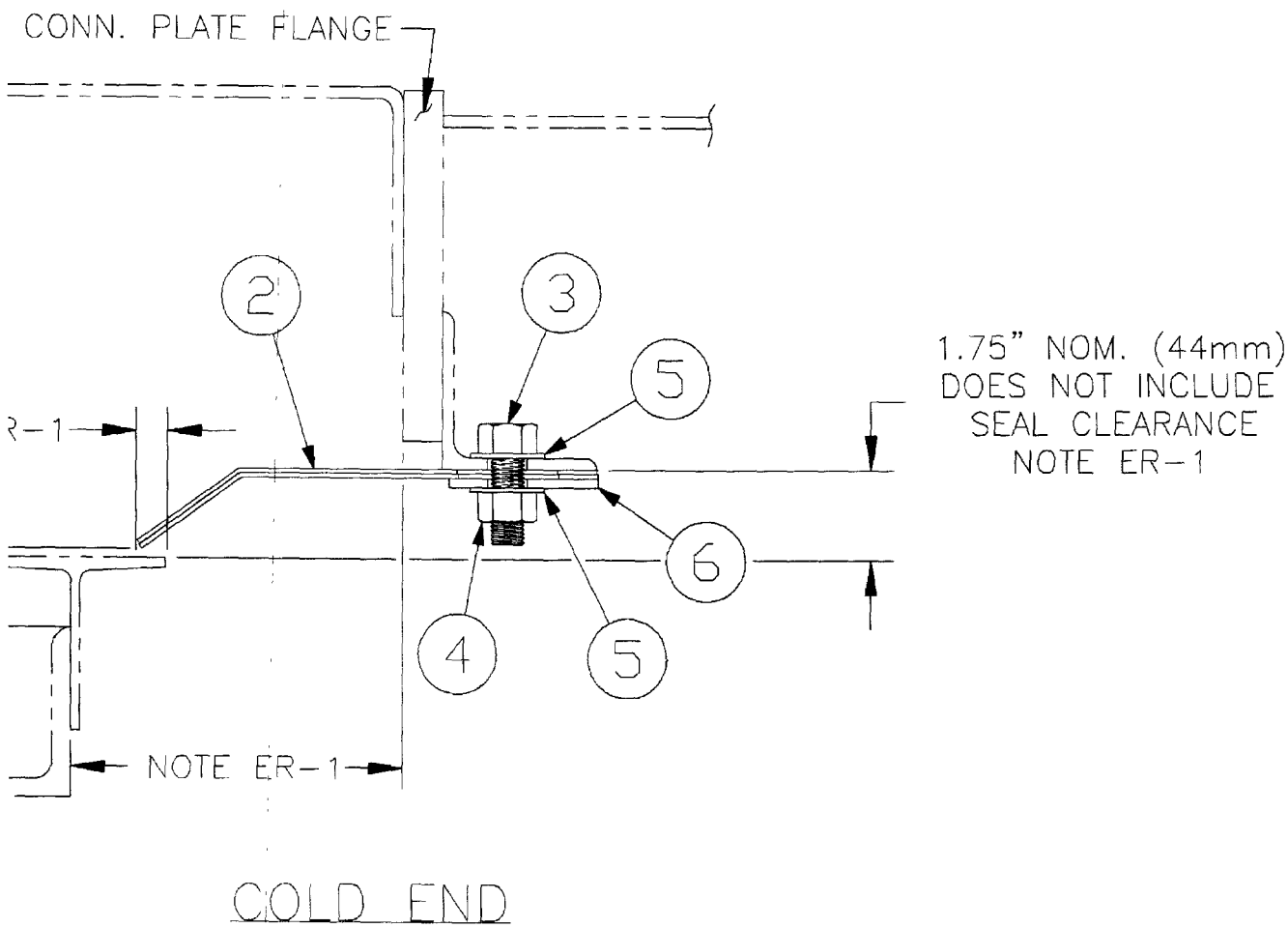
J			
I			
H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	ALT.	CKD.
ALTERATIONS			

BILL OF MATERIAL

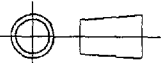
REF	DRAWING NO.	QTY.	MATL	DESCRIPTION	S.L.
1	B-99296	TAB "N"		BYPASS SEAL (HOT END) ASS'Y # "R" ARRG'T #1	SL
2	B-99296	TAB "N"		BYPASS SEAL (COLD END) ASS'Y # "R" ARRG'T #2	SL
3	P-12-25404	TAB "P"	3201	63" X 1.5" HEX HD. CAPSCREW	SL
4	P-10-25412	TAB "P"	3205	63" FIN. HEX. NUT	SL
5	P-10-25413	TAB "Q"	3214	.63" WASHER	SL
6	E-67599	TAB "S"		BYPASS SEAL HOLDING STRIP	SL

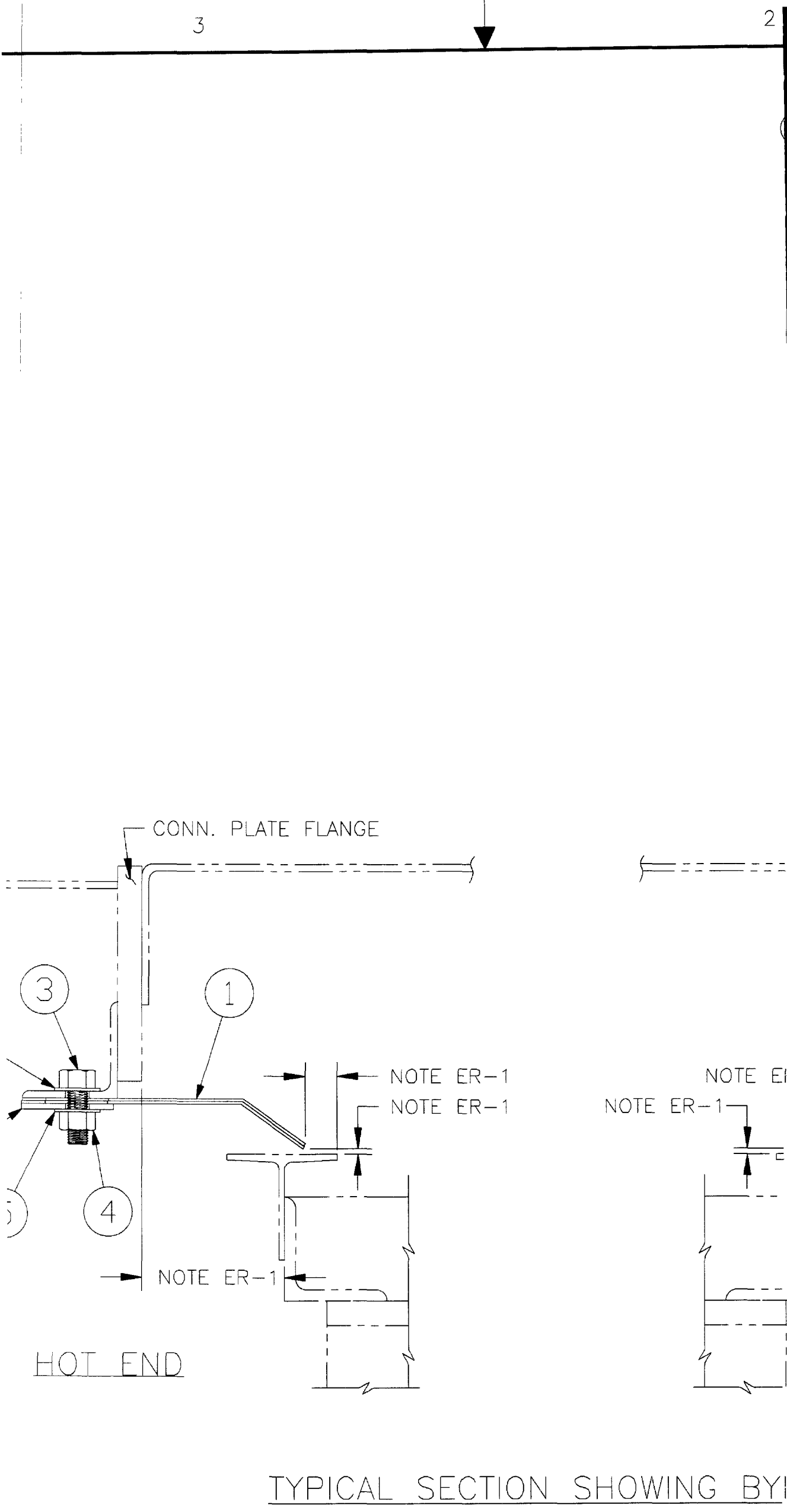
NOTES TO ERECTOR

- ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106 AND GROUP 7000 SHEET.
- ER-2 LINE UP FIRST BYPASS SEAL WITH HOLES IN CONNECTING PLATE SEAL ANGLE. TRIM SEALS TO FIT AGAINST SEAL PLATE AND SECTOR PLATE



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SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED				ALSTOM Power Inc. Air Preheater Company Wellsville, New York				
	THIRD ANGLE								
SUPERSEDES	SUBJECT AIR PREHEATER			EE-ZEE(TM) BYPASS SEAL FIELD ASS'Y.					
	API NO.								
	SIZE V-VI-H								
	DR CRW		CK DPV		CODE	GROUP	SIZE	DWG NO.	REV
	APPR. BY				ER	0505	C	99297	B
DATE 02-11-2000				SCALE NTS		WT		SHEET OF	



TABULATION							
ASS'Y. NO.	HEATER SIZE	TAB "N"	TAB "P"	TAB "Q"	TAB "R"	TAB "S"	APPROX. WEIGHT
1	24.5	22	176	352	1	44	650#
2	25	22	176	352	2	44	650#
3	25.5	24	192	384	3	48	710#
4	26	24	192	384	4	48	710#
5	26.5	26	208	416	5	52	770#
6	27	26	208	416	6	52	770#
7	27.5	28	224	448	7	56	830#
8	28	28	224	448	8	56	830#
9	28.5	34	272	544	9	68	1040#
10	29	34	272	544	10	68	1040#
11	29.5	36	288	576	11	72	1100#
12	30	38	304	608	12	76	1160#
13	30.5	40	320	640	13	80	1220#
14	31	40	320	640	14	80	1220#
15	31.5	42	336	672	15	84	1280#
16	32	44	352	704	16	88	1345#
17	32.5	46	368	736	17	92	1525#
18	33	48	384	768	18	96	1590#
19	33.5	50	400	800	19	100	1665#
20	34	54	432	864	20	108	1790#
21	34.5	56	448	896	21	112	1900#
22	35	60	480	960	22	120	2023#
23	35.5	62	496	992	23	124	2090#
24	36	64	512	1024	24	128	2156#
25	29	34	272	544	25	68	1040#

D

C

B

A



H				
G				
F				
E				
D				
C				
B	8-3-04	DV	ACS	ADDED ARRGT TO REF #1 & 2 IN BILL OF MAT'L
A	3-6-03	JRC	JRC	REMOVED SEQ. NOTES, ADD ALSTOM BORDER
MARK	DATE	DR.	CK	DESCRIPTION
ALTERATIONS				

DECIMAL	FRACTIONAL EQUIVALENT
0.03	1/32
0.06	1/16
0.09	3/32
0.13	1/8
0.16	5/32
0.19	3/16
0.22	7/32
0.25	1/4
0.28	9/32
0.31	5/16
0.34	11/32
0.38	3/8
0.41	13/32
0.44	7/16
0.47	15/32
0.50	1/2

DECIMAL	FRACTIONAL EQUIVALENT
0.53	17/32
0.56	9/16
0.59	19/32
0.63	5/8
0.66	21/32
0.69	11/16
0.72	23/32
0.75	3/4
0.78	25/32
0.81	13/16
0.84	27/32
0.88	7/8
0.91	29/32
0.94	15/16
0.97	31/32
1.00	1

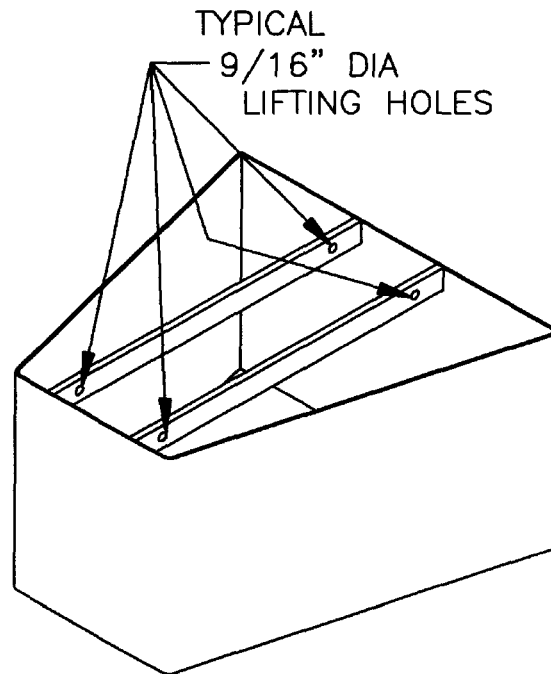
THIS DRAWING IS THE PROPERTY OF ABB AIR PREHEATER, INC. AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE ABB AIR PREHEATER, INC.

H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	DR.	CK.
ALTERATIONS			

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	 THIRD ANGLE				<b>ABB AIR PREHEATER, INC.</b> WELLSVILLE, NEW YORK		
	SUBJECT AIR PREHEATER		DECIMAL TO FRACTIONAL REFERENCE TABLE					
	API NO.							
	SUPERSEDES	SIZE V-VI-H		CODE	GROUP	SIZE	DWG NO.	REV
		DR VB	CK	ER	2200	E	98856	
APPR. BY								
DATE 06-30-99		SCALE NTS		WT		SHEET OF		

IP7\_033876

03062713

TYPICAL LIFTING ARR'G'T.NOTES TO ERECTOR:

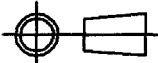
BASKETS TO BE LIFTED WITH 4 POINT LIFT. LIFTING HOLES ARE PROVIDED IN HOLDING BARS FOR CLEVISES OR SHACKLES. SIZE CLEVISES OR SHACKLES FOR A MAXIMUM 2400 LB. BASKET WEIGHT.

LIFTING EQUIPMENT FURNISHED BY OTHERS.

TO BE USED ON 90 DESIGN AND FULL WRAPPER BASKETS ONLY.

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

H			
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D			
C			
B			
A			
MARK	DATE	DR.	CK.
ALTERATIONS			

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		 THIRD ANGLE		<b>ALSTOM</b>					<b>ALSTOM Power, Inc.</b> <b>Air Preheater Company</b> Wellsville, New York		
	SUBJECT							LIFTING ARRANGEMENT				
	AIR PREHEATER											
	API NO.											
	SUPERSEDES	SIZE V-VI										
DR BLM		CK CU		CODE	GROUP	SIZE	DWG NO.		REV			
APPR. BY CU				ER	0200 0202	E	99502					
DATE 06-23-00							SCALE NTS		WT		SHEET OF	

BILL OF MATERIAL			
QTY.	MAT'L.	DESCRIPTION	S.L.
48		T-BAR TAB	S.L.
48		T-BAR TAB	S.L.
48		SPLICE BAR	S.L.
48		T-BAR (ASS'Y. #3)	S.L.
288	3201	0.63 X 1.75 HEX. HEAD CAPSCREW	S.L.
288	3205	0.63 FIN. HEX. NUT	S.L.
576	3221	0.63 WASHER	S.L.

D

BARS AND T-BAR TABS.  
BETWEEN THE ROTOR SHELL AND THE DIAPHRAGM FOR FRACTURES.  
OUND, REMOVE THE EXISTING WELD TWO INCHES BEYOND THE  
IRE AND REWELD AS SHOWN IN SECTION "A-A".  
, (REF. #4) WITH THE ENDS LOCATED ON THE CENTER-LINES OF  
TMENTS AND TO THE RADIUS SHOWN WITH A TOTAL RUN-OUT OF  
LTS, NUTS, AND WASHERS ARE TO BE INSTALLED EXACTLY AS  
"A-A". TIGHTEN ALL BOLTS PRIOR TO WELDING.  
#4) AND SPLICE BAR (REF. #3) AS SHOWN IN DETAIL "X" AND


C

DS (REF. #5) TO WASHERS (REF. #7) ACROSS FLATS 180° APART,  
D THE WASHERS TO THE ANGLES 180° APART FOR 0.75".  
F. #6) AND THEN TORQUE TO 20 FT./LBS. THEN TACK WELD  
NOT TACK WELD THE NUT TO THE WASHER OR WASHER TO THE

BS (REF. #1 & #2) AS SHOWN IN SECTION "B-B". WELD TO  
INSTALL REF. #1 ON TRAILING SIDE OF RADIAL SEALS AND REF. #2

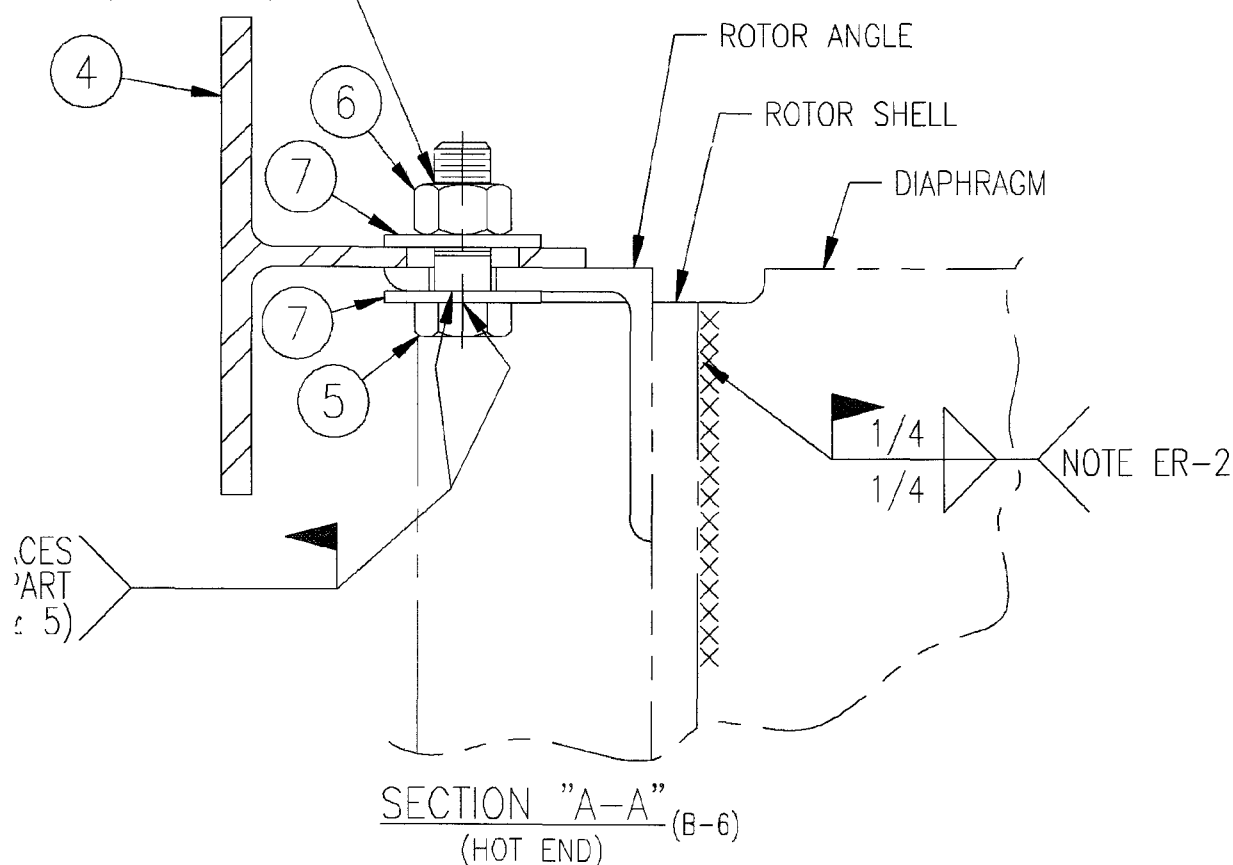
B

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY  
AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE  
OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS  
OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON  
WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

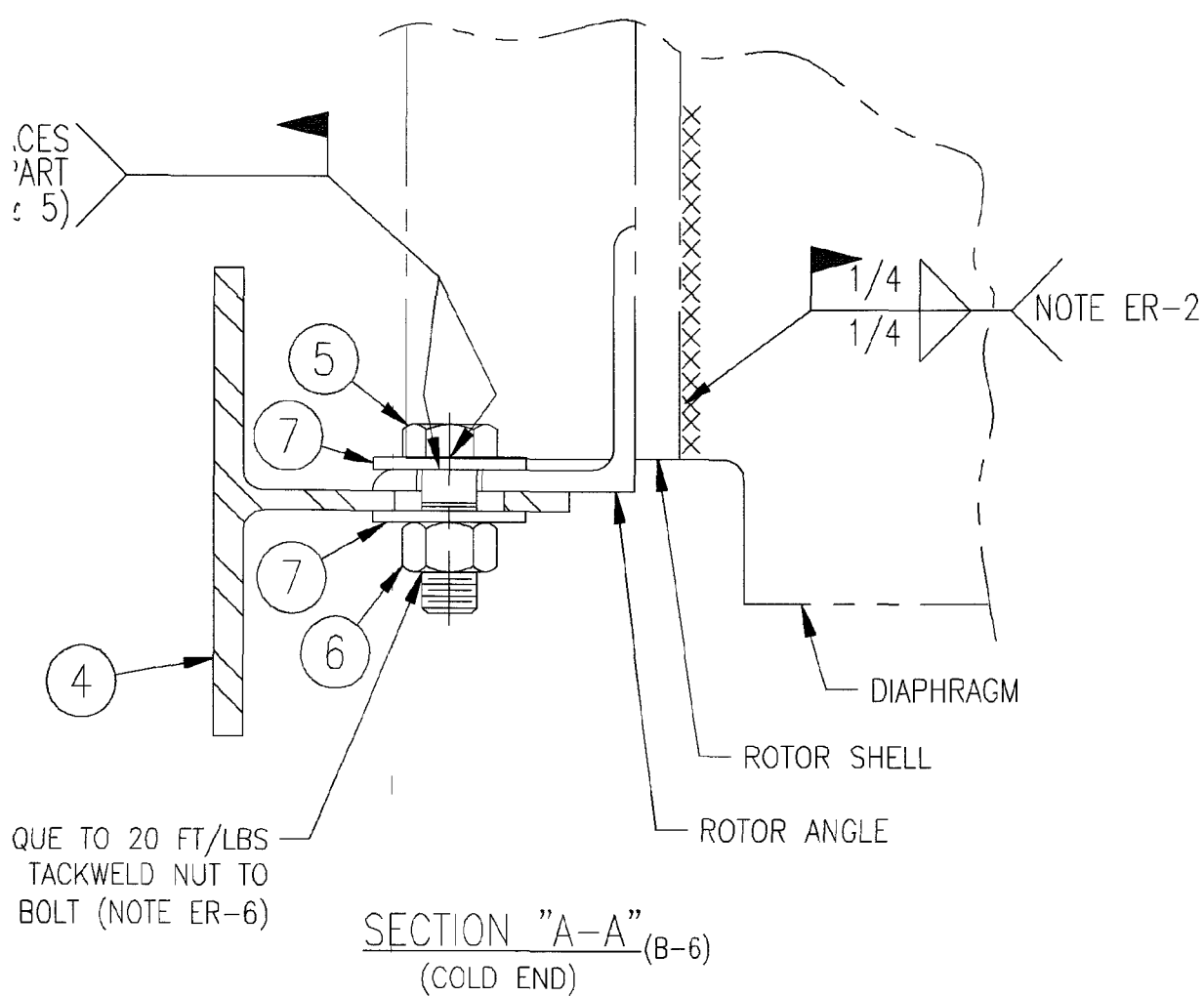
		ALSTOM Power Inc. Air Preheater Company Wellsville, New York		
HOT & COLD END FLOATING T-BAR INSTALLATION				
CODE	GROUP	SIZE	DWG NO.	REV
ER	0103	D	10041587	
SCALE NTS		WT	SHEET	OF

A

QUE TO 20 FT/LBS  
TACKWELD NUT TO  
BOLT (NOTE ER-6)

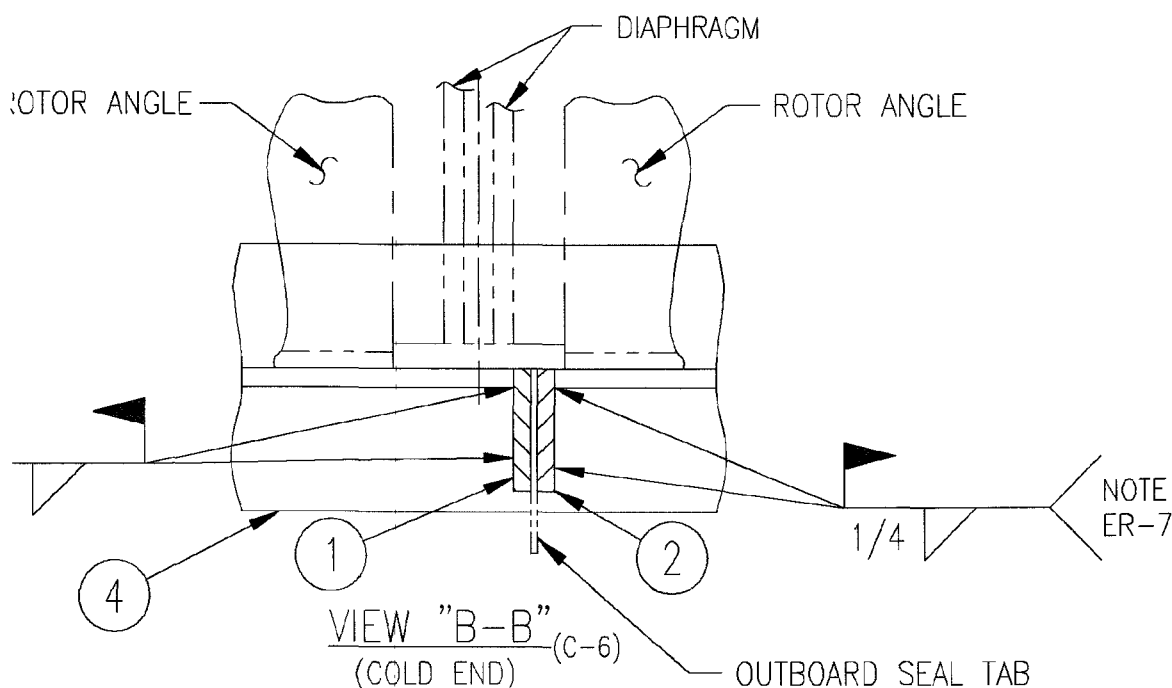
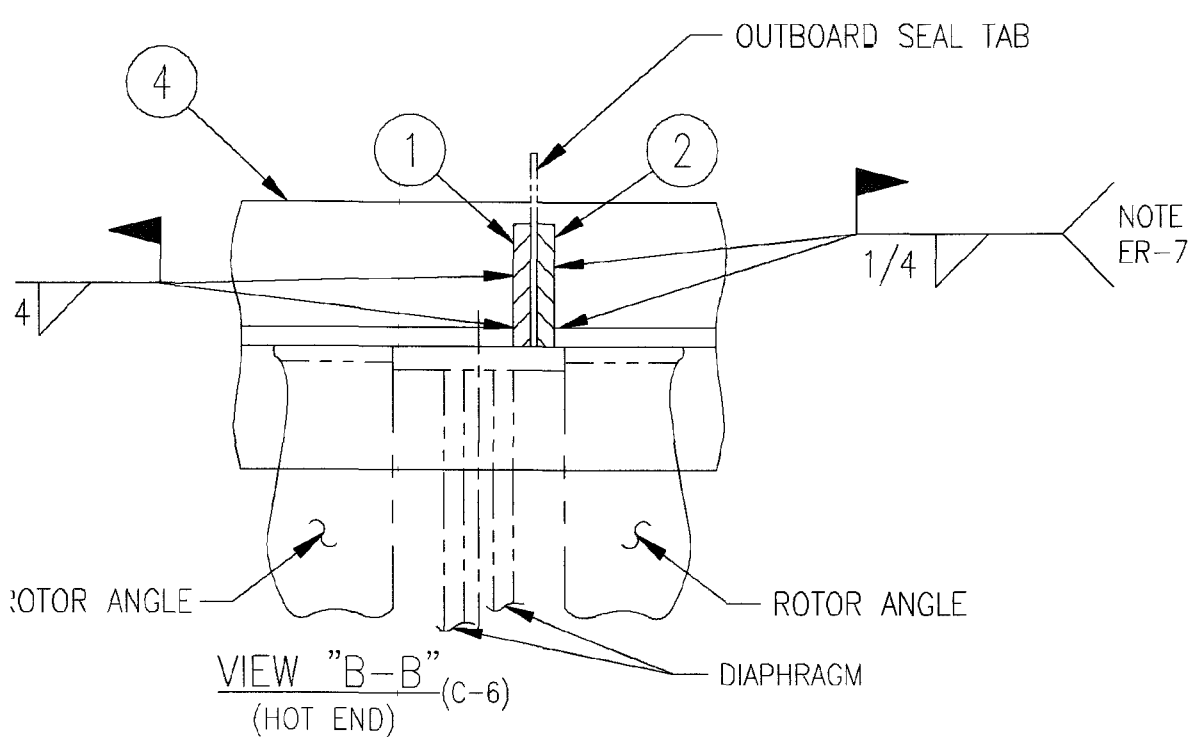


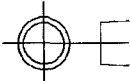
REF.	DRAWING NO.
1	E-77351
2	E-77345
3	E-95943
4	B-77352
5	P-14-31500
6	P-10-1420
7	P-6-1289

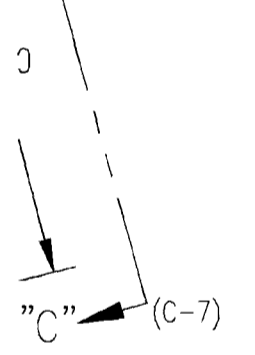


#### NOTES TO ERECTOR:

- ER-1 REMOVE EXISTING T  
ER-2 INSPECT THE WELD  
IF FRACTURES ARE  
END OF THE FRACT  
ER-3 INSTALL THE T-BAR  
THE ROTOR COMPAR  
0.13". ALL THE BC  
SHOWN IN SECTION  
ER-4 WELD T-BARS (REF  
VIEW "C-C".  
ER-5 TACKWELD BOLT HE  
AND THEN TACK WE  
ER-6 BACK OFF NUTS (RI  
BOLT TO NUT. (DC  
T-BAR).  
ER-7 WELD THE T-BAR T  
THE T-BAR ONLY.  
ON LEADING SIDE.



SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED		
			THIRD ANGLE
SUPERSEDES	SUBJECT		
	AIR PREHEATER		
	API NO.		
	SIZE 33.5 VI (MOD		
	DR GP		CK DV
	APPR. BY		
	DATE 12/16/04		



TACKWELD 2 PL  
180° AF  
(NOTE ER-3 &

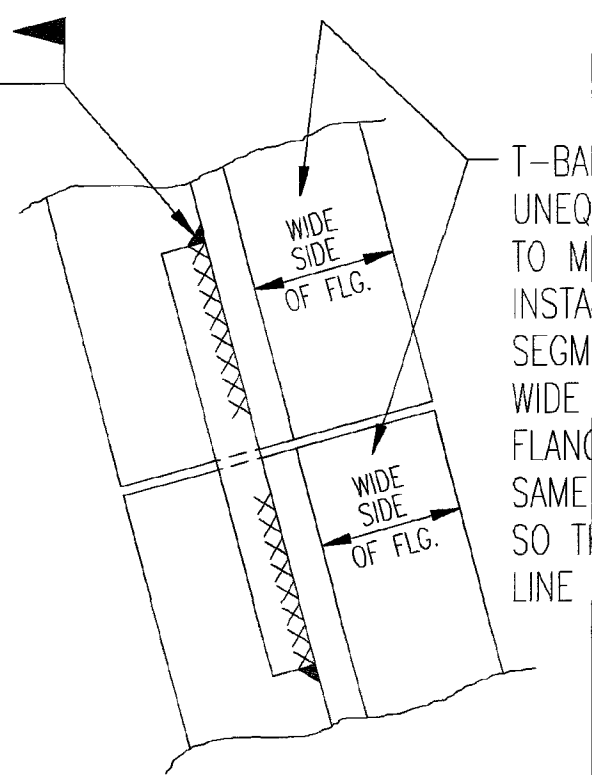
NOTE  
ER-7  $1/4$

PARTIAL HOT END VIEW

D

3 SIDES DO NOT WELD  
ACROSS SPLIT IN T-BAR  
NOTE ER-4

1/4



VIEW "C-C" (B-7)

C



B

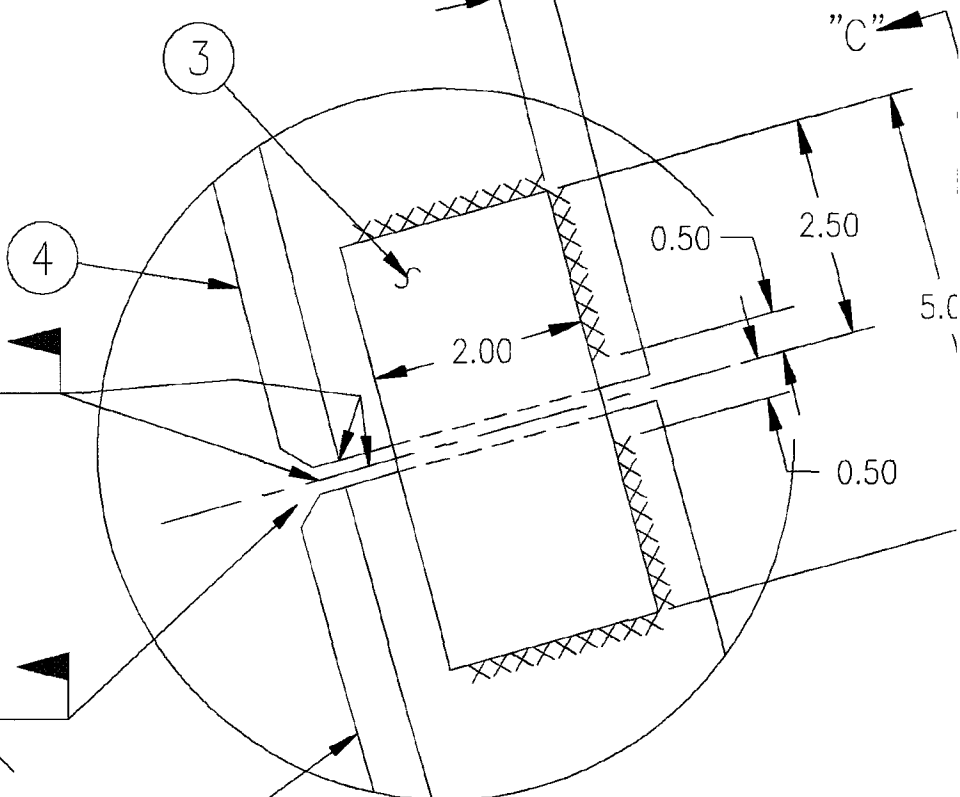
NOTE ER-4

1/8

NOTE ER-4

1/8

G

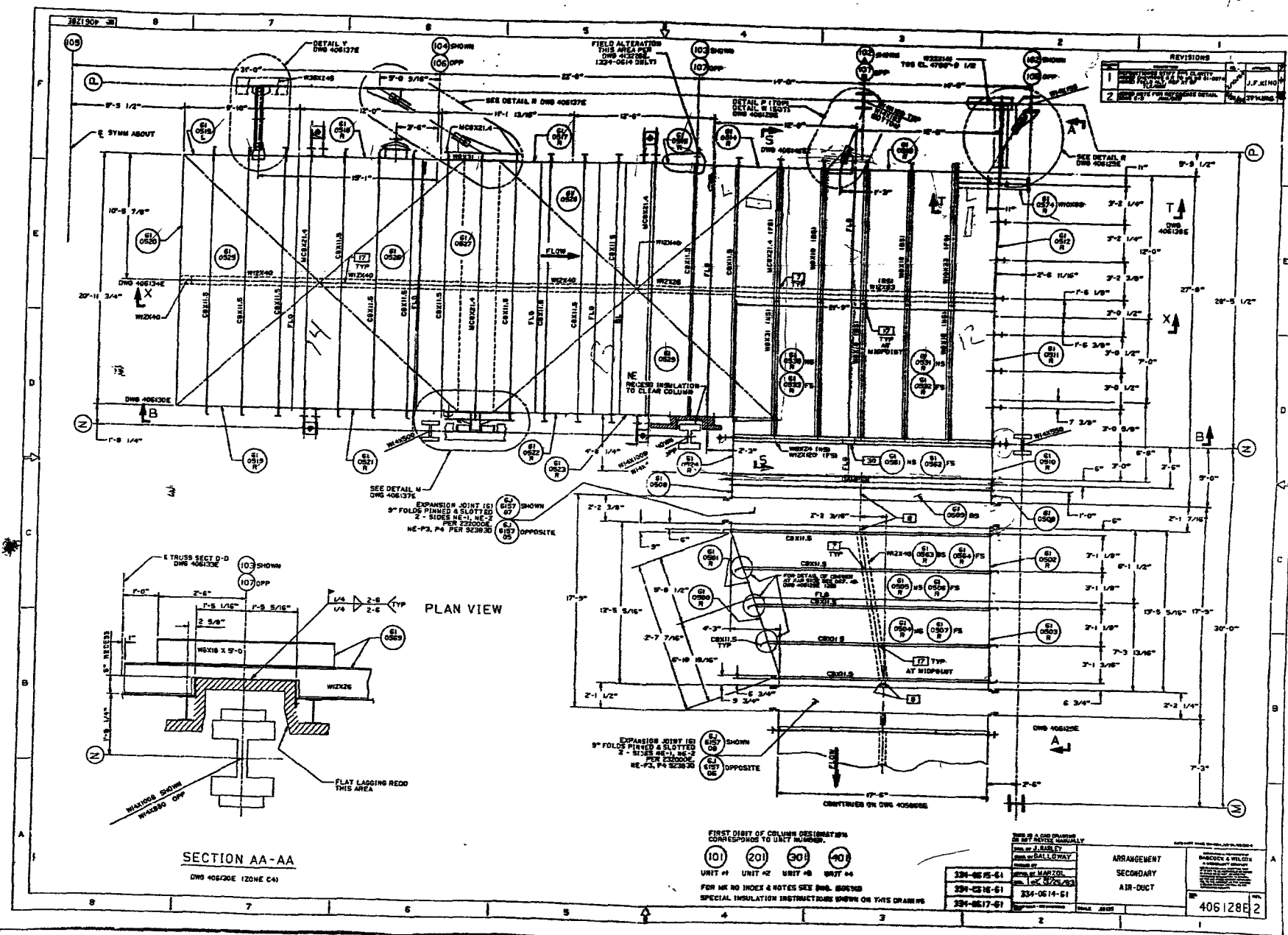


DETAIL "X" (B-6)

A

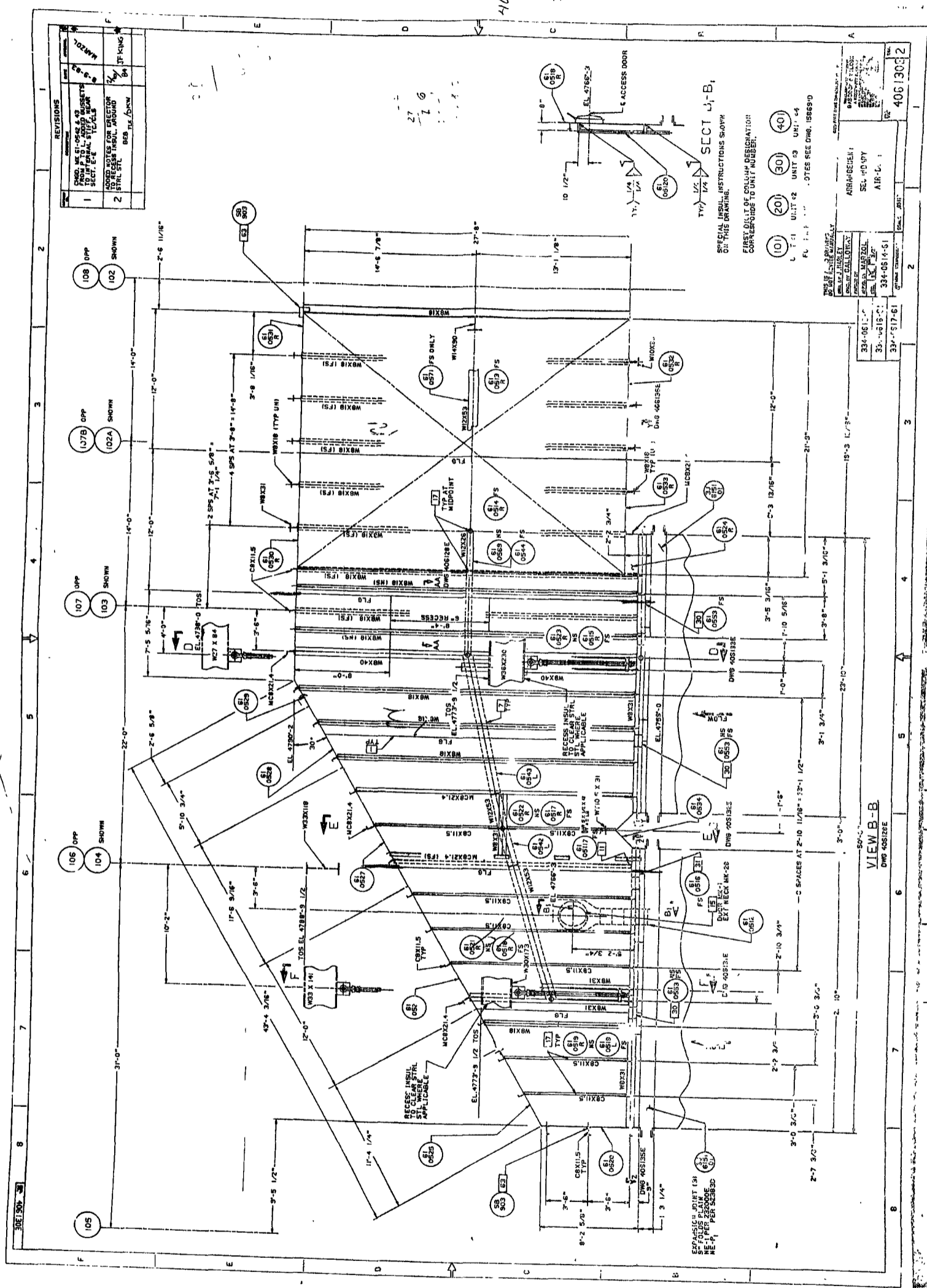
H				
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E				
D				
C				
B				
A				
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

[4098/04

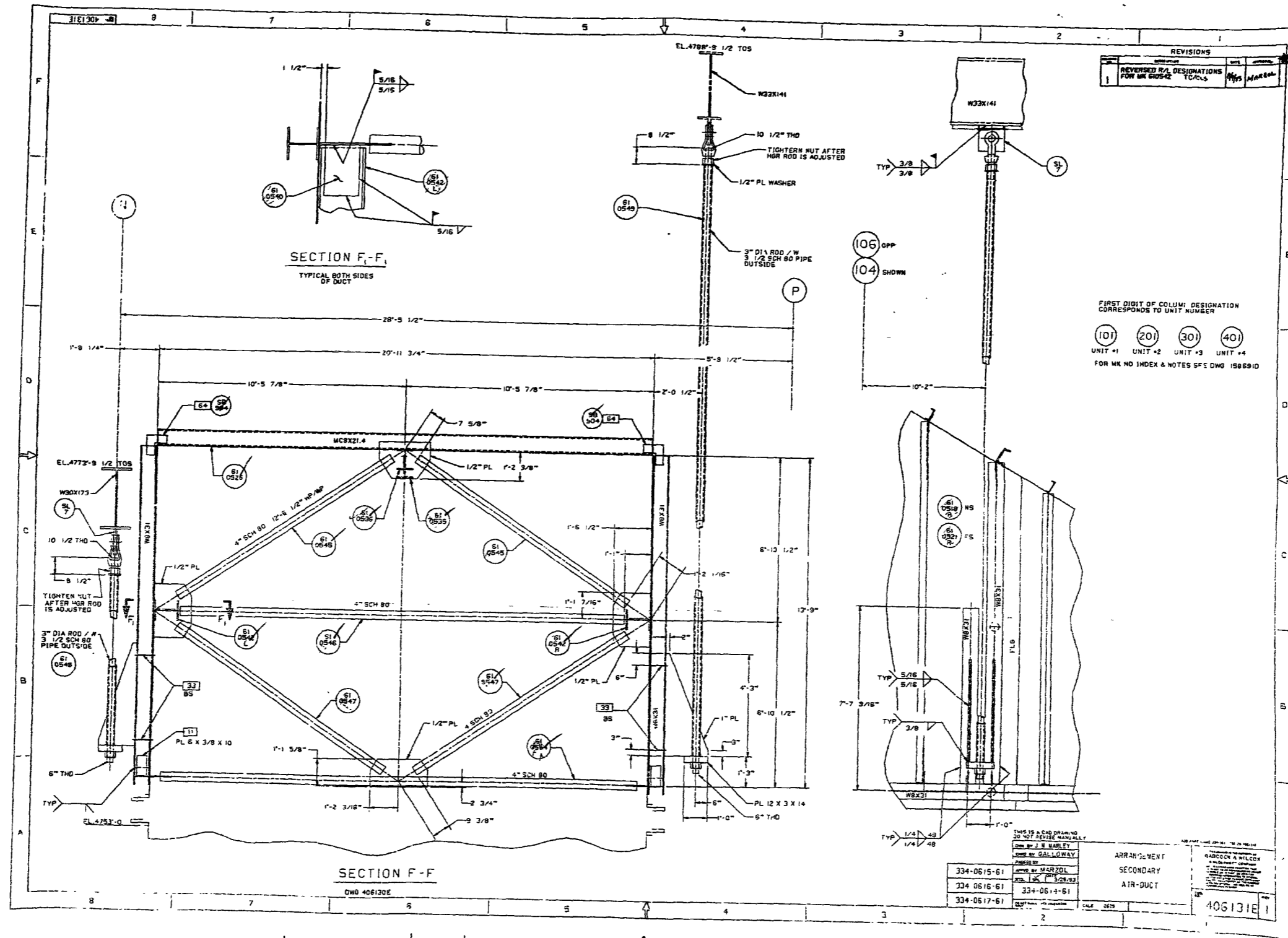


406128 E-2.  
STK 21

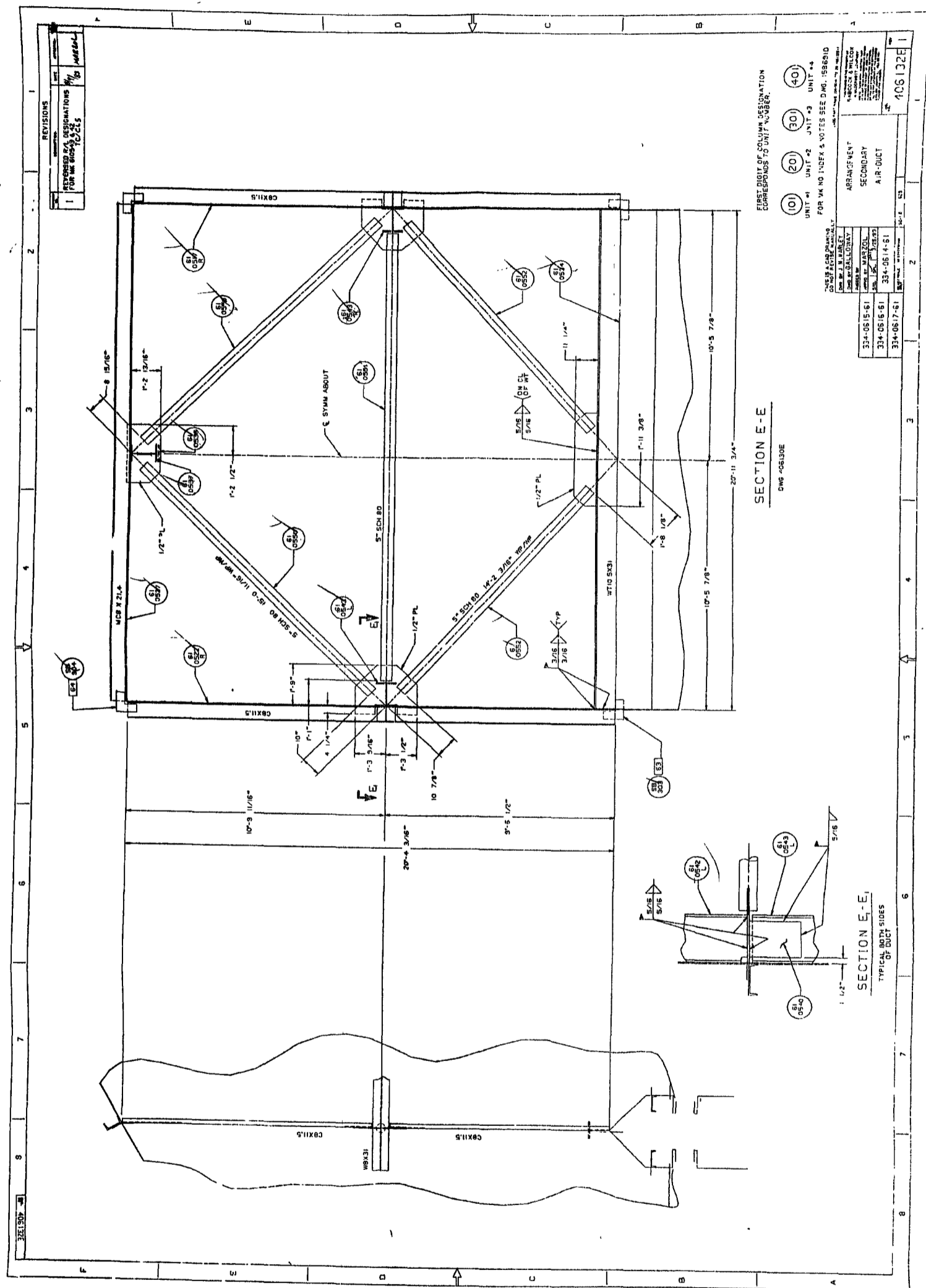




406130E-2  
 27  
 1 6  
 21

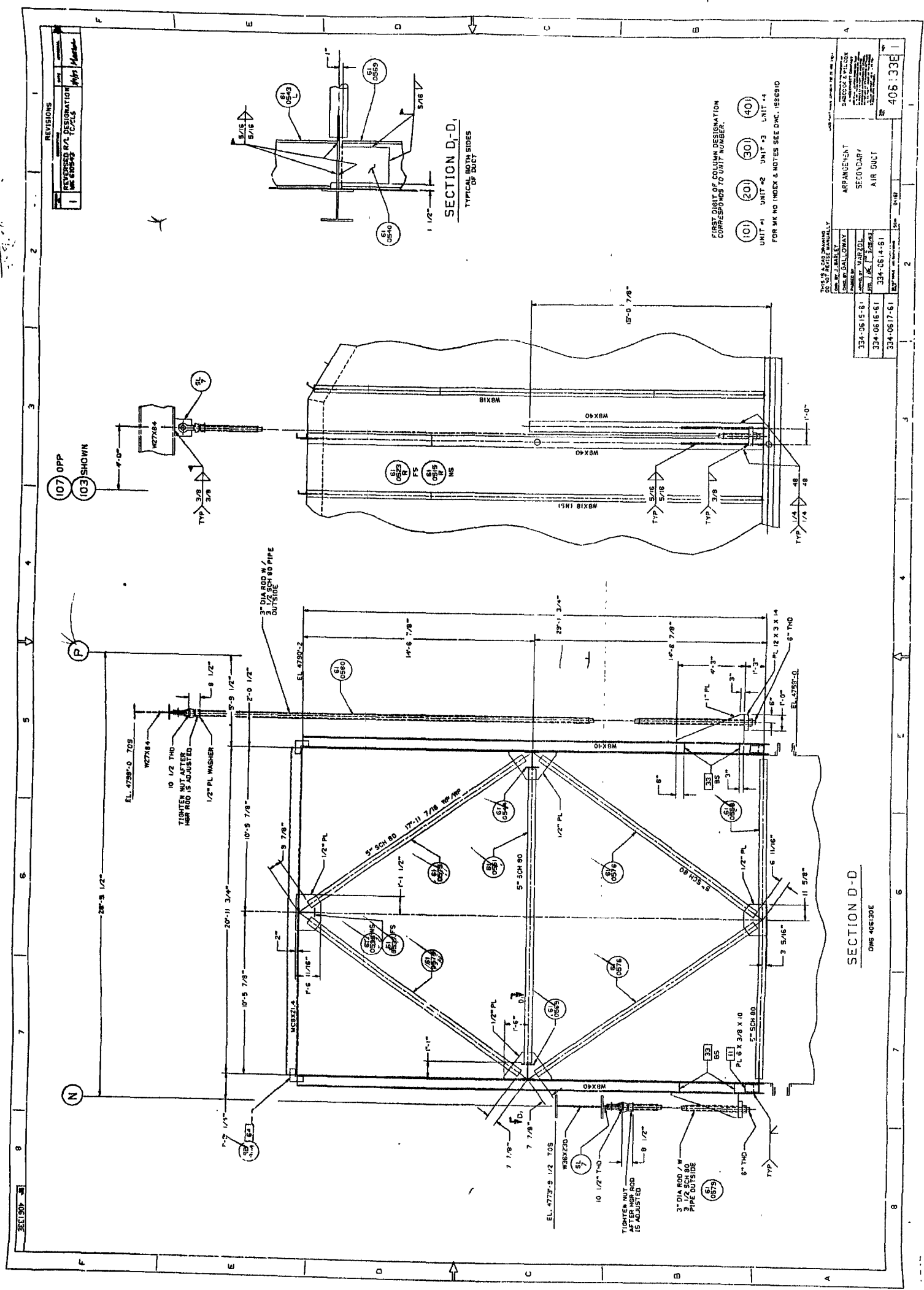


21



5.9.5  
5.9.5  
5.9.5

5.9.5.82



SECTION D-D  
DWG 4061336

REVISIONS	NO.	DATE	BY	CHKD	APP'D
1	5.9.5.82	5.9.5.82	5.9.5.82	5.9.5.82	5.9.5.82

UNIT 41	UNIT 42	UNIT 43	UNIT 44
(101)	(201)	(301)	(401)

FIRST DIGIT OF COLUMN DESIGNATION  
CORRESPONDS TO UNIT NUMBER.

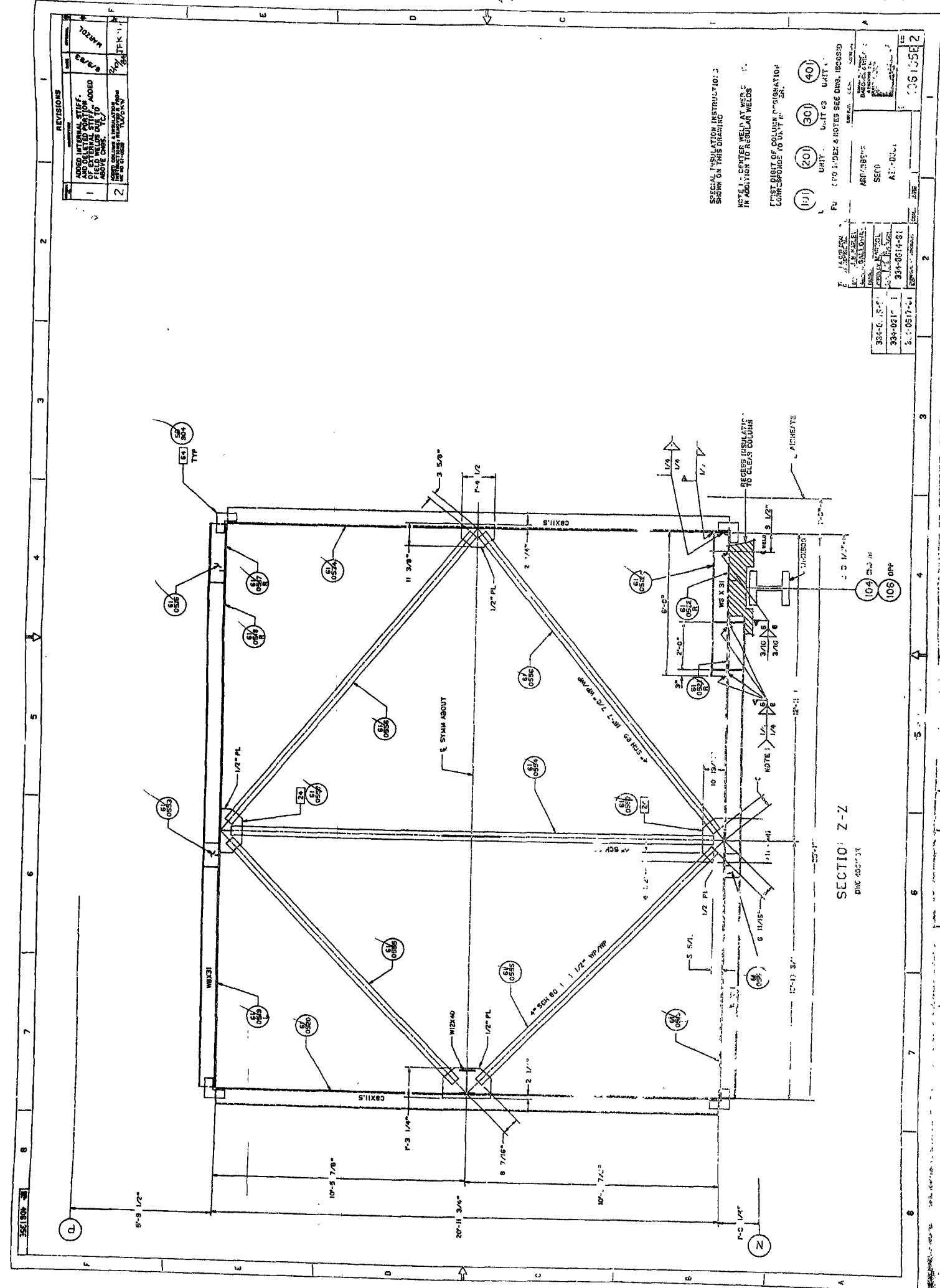
FOR ME NO INDEX & NOTES SEE DMC 1556510

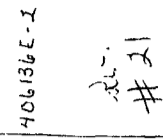
334-0515-81	334-0516-81	334-0517-81
334-0518-81	334-0519-81	334-0520-81

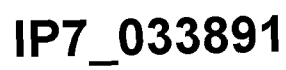
ARRANGEMENT	SECONDARY	AIR DUCT
4061336	4061336	4061336



416135E 2  
2.1  
# 21

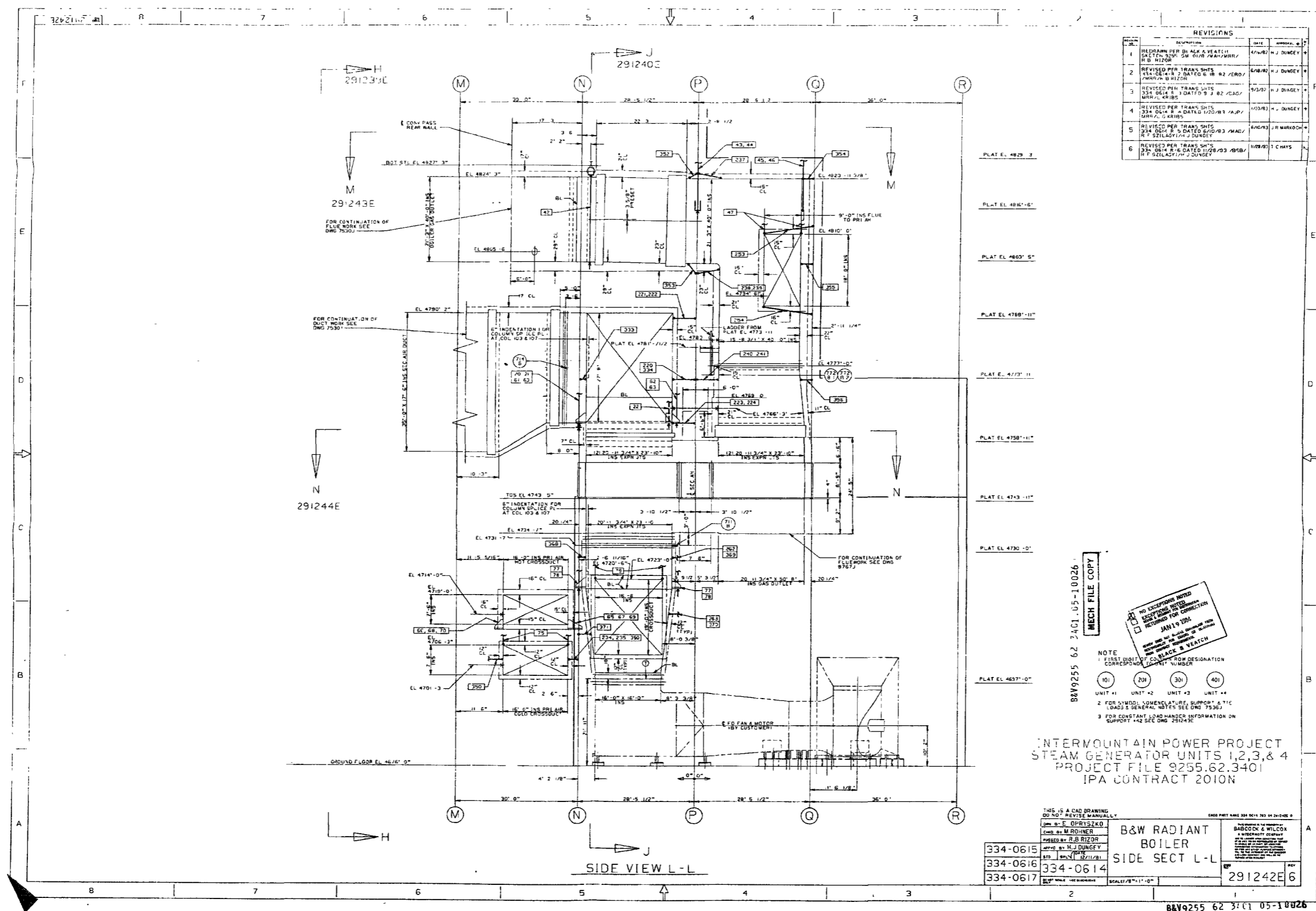














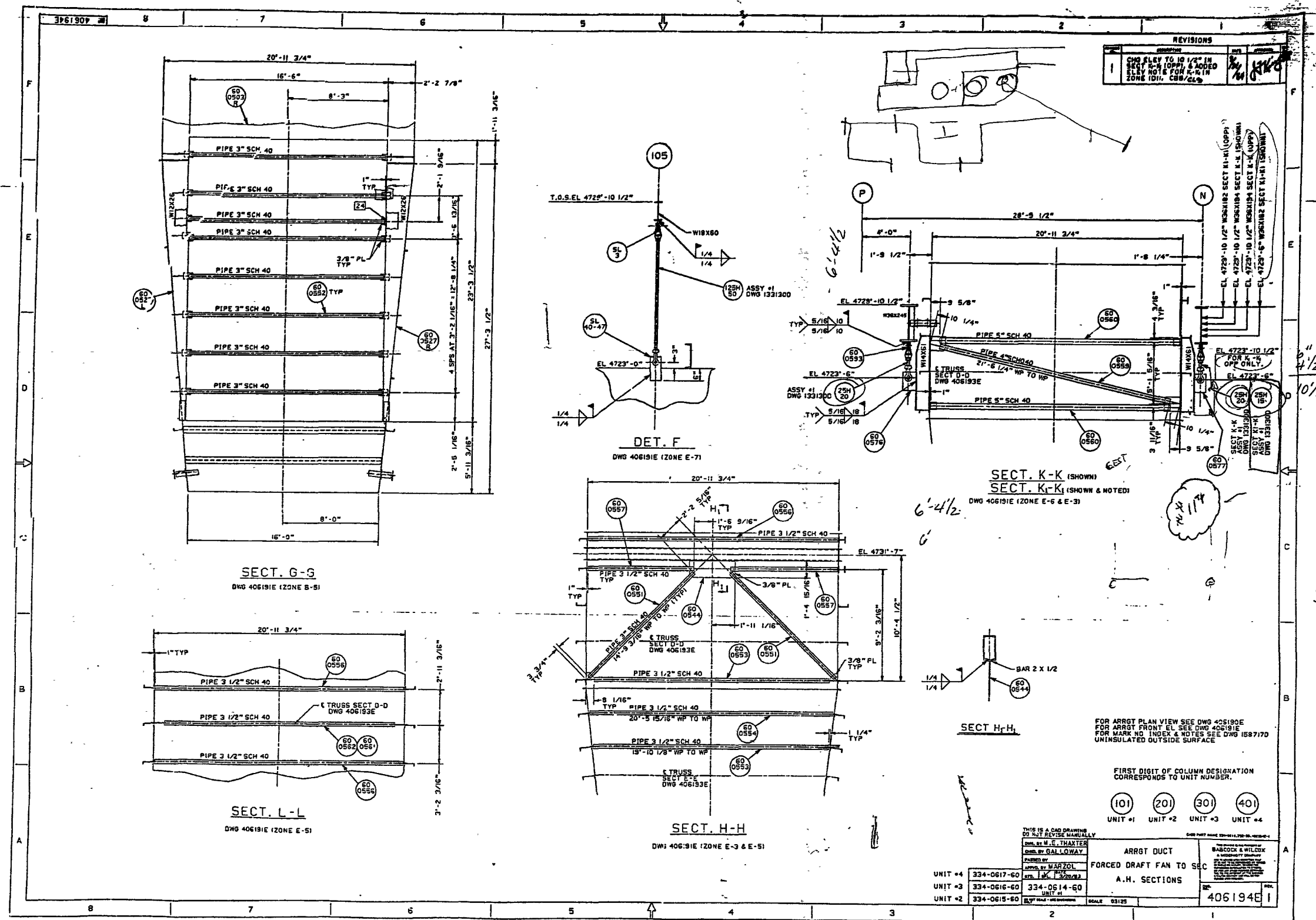
000





U: CURRENT A.H.  
SCAFFOLDING

**IP7\_033898**





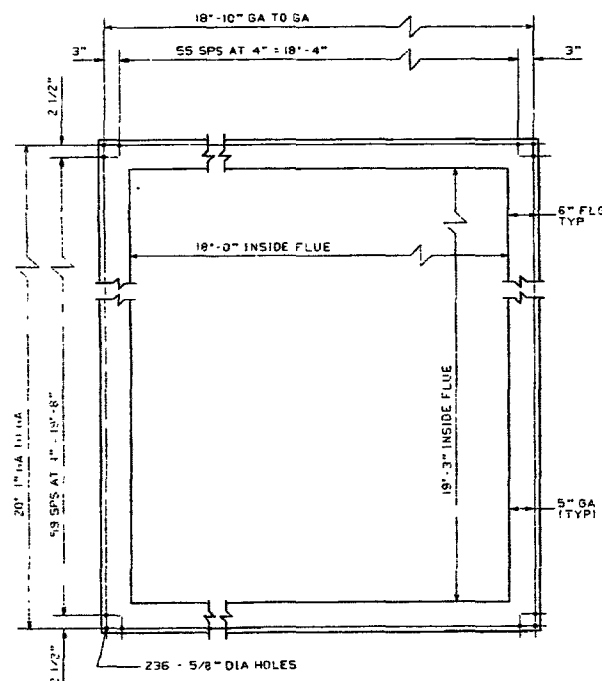


AIR HEATER FLUE SUPPORTS IN KIPS																							
SUPP RT	NO.	UPLIFT (TYP. MIN. ON UP OR DN)	PRESS LOAD UP OR DN	TRAN PRESS. LOAD		VER. TO UP OR DN	EARTHQUAKE S TO S F & A					PRESS LOAD F & A	TRAN PRESS LOAD	FRICTION LOAD			DEAD WEIGHT	SNOW LOAD	16" ASH LOAD	12" ASH LOAD	WIND LOAD	PLATE DEAD LOAD	PLATE LIVE LOAD
				UP	DN		★	⊗	★	⊗	★			★	S TO S	F & A							
1			8	23	13	11	7									31		50	24				
2			8	23	13	11	7									30		50	24				
3			21	65	35	34	34						41	41	69		207	98					
4			21	65	35	60	150			171	285	22 1/2	68 1/2		41	117	388	183					
5	4		21	65	35	71	76	104	173				41	38	61		192	91					
6			21	65	35	57	143	199	332	162	270	22 1/2	68 1/2		38	109	372	176					
7						21	52									45	126	60					
8						21	52									45	126	60					
9						25	61			149	249	2 1/2	5 1/2	28	70	53	6	119	57		1	2	
10						26	65			64	107	2 1/2	5 1/2	33	31	46	8	160	76		1	2	
11						22	54	246	40	72	120	2 1/2	5 1/2	50	35	49	6	111	53	10	1	5	
12						17	43						18	18	48	4	63	30			1	2	
13						17	43						17	17	57	3	52	25			5	6	
14						29	71						33	33	73	7	135	64			5	11	
15						21	70						35	35	48	3	173	82			2	9	
16						27	66	322	537				60	30	62	7	131	62	12		5	13	
17		8	23	13	11	27										31		50	24				
18		8	23	12	11	27										30		50	24				
19		21	65	35	34	84							41	41	69	207		207	98				
20		21	65	35	60	150				171	285	22 1/2	68 1/2		41	117	388	183					
21	4		21	65	35	31	76	104	173				41	38	61		192	91					
22			21	65	35	57	143	199	332	162	270	22 1/2	68 1/2		38	109	372	176					
23						21	52									45	126	60					
24						21	52									45	126	60					
25						25	61			149	249	2 1/2	5 1/2	28	70	53	6	119	57		1	2	
26						26	65			64	107	2 1/2	5 1/2	33	31	46	8	160	76		1	2	
27						22	54			72	120	2 1/2	5 1/2	50	35	49	6	111	53		1	3	
28						17	43						18	18	48	4	63	30			1	2	
29						17	43						17	17	57	3	52	25			5	6	
30						29	72						33	33	73	7	135	64			5	11	
31						28	70						35	35	48	3	173	82			2	9	
32						27	66						60	30	62	7	131	62			5	11	

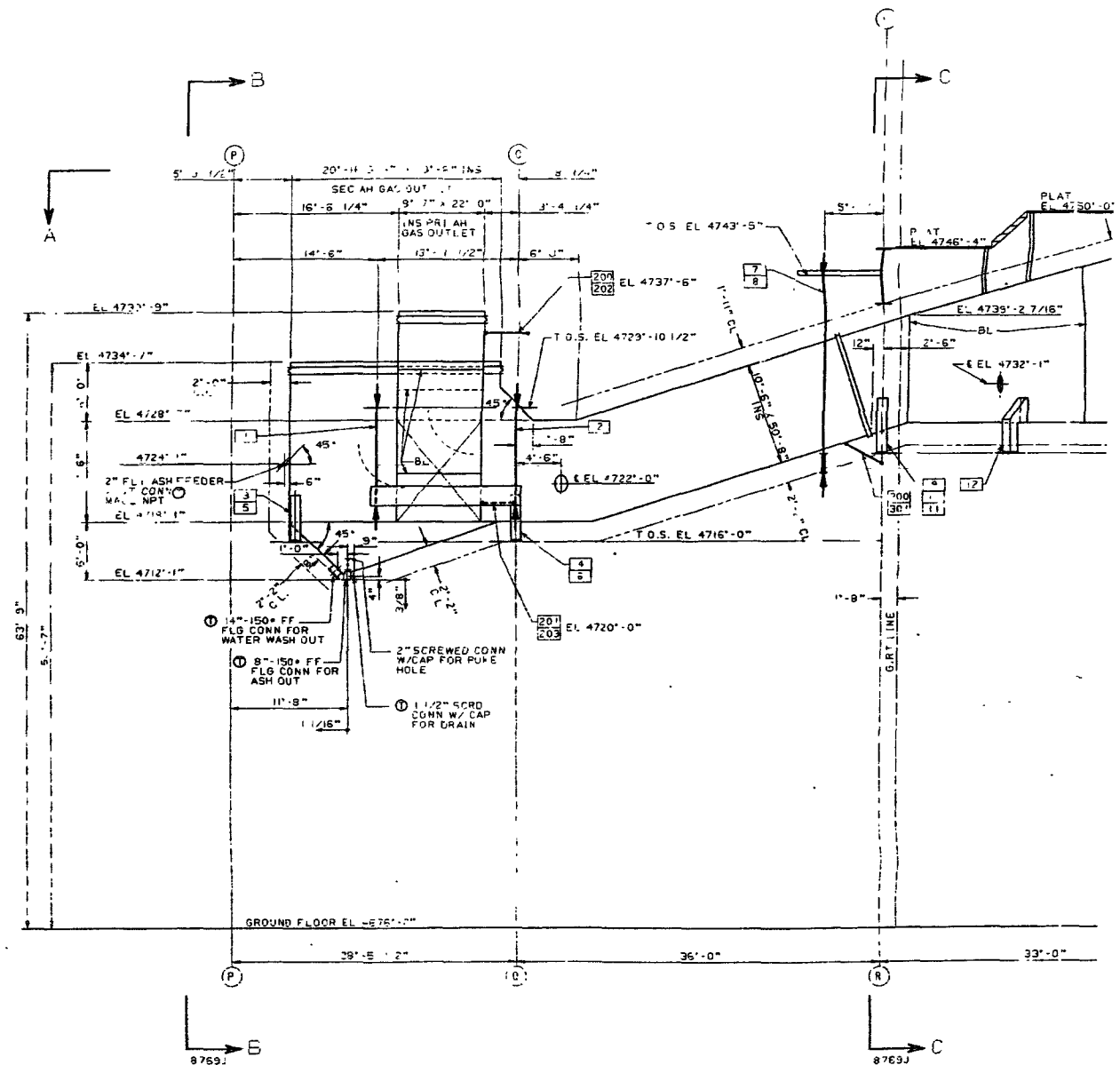
SIDE TO SIDE TIES IN KIPS	
TIE NO.	EARTHQUAKE
300	63 105
301	63 105

FORE & AFT TIES IN KIPS	
TIE NO.	EARTHQUAKE
200	11 19
201	22 37
202	11 19
203	22 37

\* VERTICAL EARTHQUAKE IS EQUAL TO 0.20 TIMES THE DEAD WEIGHT.  
 \* HORIZONTAL EARTHQUAKE IS EQUAL TO 0.30 TIMES THE DEAD WEIGHT.  
 \* FRICTION LOAD, FORE & AFT OR SIDE TO SIDE IS EQUAL TO 0.15 TIMES THE DEAD WEIGHT.  
 \* EARTHQUAKE LOADS FOR DESIGN OF SUPPORT FRAMES AND ANCHOR ASSEMBLIES INCLUDING ANCHOR BOLTS BASED ON 0.5 TIMES THE DEAD WEIGHT.  
 EARTHQUAKE LOAD IS BASED ON 1.7" OF ASH IN FLUE.



SECTION D-D  
SCALE 1" = 1'-0"



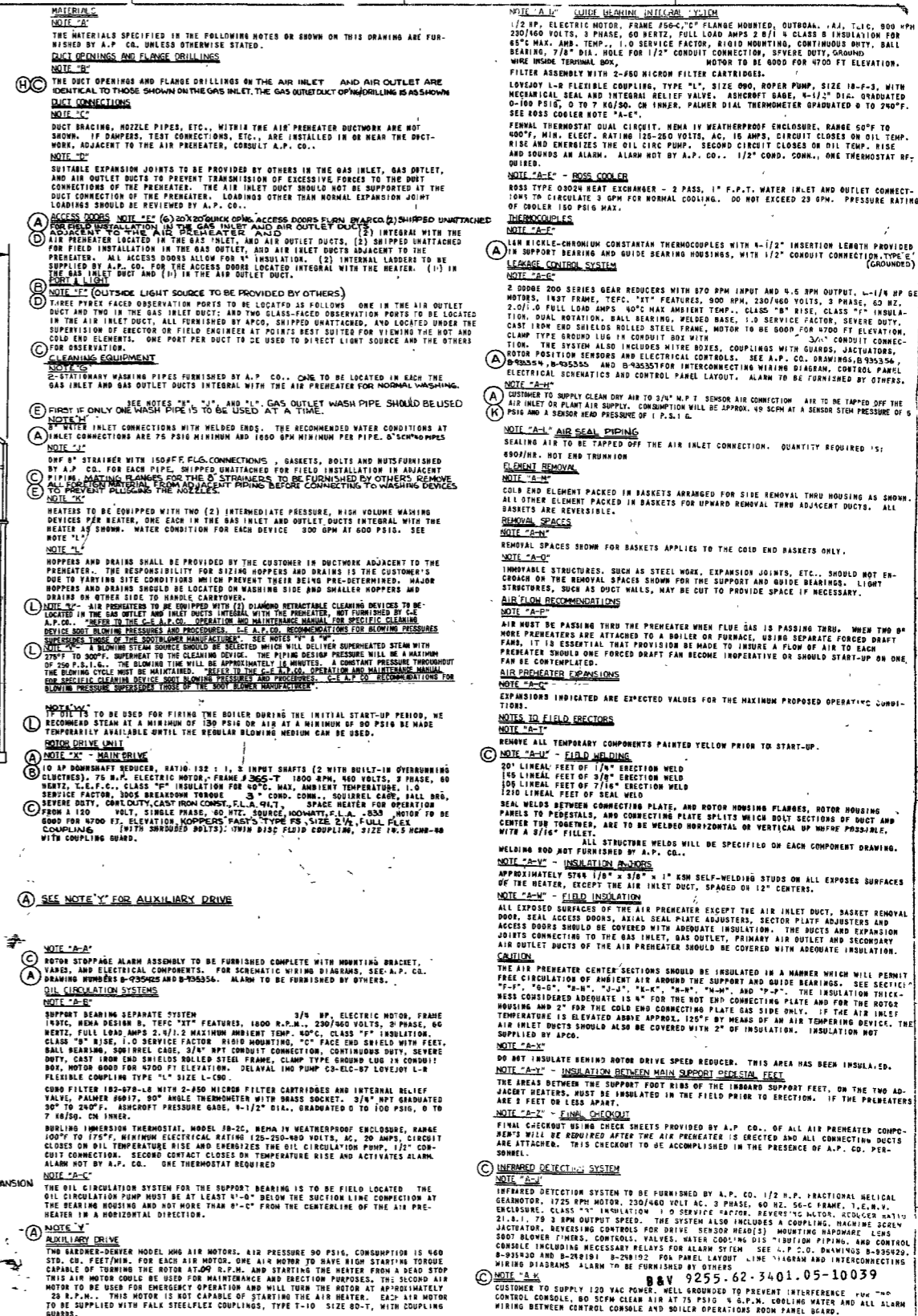
F1

62V 9255 60.3401.05-10203

8767J

IP7\_033901





EQUIPMENT DESCRIPTION	CUSTOMER TAG NO. *	CUSTOMER TAG NO. *
SECONDARY AIR PREHEATER	XSQB-AHT-1A	XSQB-AHT-1B
ROTOR DRIVE UNIT MAIN DRIVE	XSGB-MAHT-1A	XSGB-MAHT-1B
SUPPORT BEARING OIL CIRC. SYSTEM	XSGB-OLU-1A2	XSGB-OLU-1B2
GUIDE BEARING OIL CIRC. SYSTEM	XSGB-OLU-1A3	XSGB-OLU-1B3
STATIONARY WAREHOUSE STRAINER FOR GAS	XSGB-STR-1	XSGB-STR-2
STATIONARY WAREHOUSE STRAINER FOR GAS	XSGB-STR-3	XSGB-STR-4

\* X IS THE ASSOCIATED UNIT NUMBER 1 THRU 4

(A)

INTERMOUNTAIN POWER PROJECT  
STEAM GENERATOR UNITS 1 THRU 4  
PROJECT FILE 9255.62.3401  
IPA CONTRACT 2010N

(A)

INTERMOUNTAIN POWER  
AGENCY  
LAP-4104  
STEAM GENERATOR UNIT-4  
LYNN DYLL, UTAH  
BARB COCK & WILCOX CO.  
ORDER NO. 6H326 CONT. NO. 8B

PIPING NOT BY A.P. CO.  
 (A) SUGGESTED PIPING SYSTEM FOR DUAL ALK.  
 SEE A.P. CO. DRAWING 8-8775 FOR DESCRIPTION  
 THIS CONTRACT IS THE PROPERTY OF THE  
 UNITED STATES OF AMERICA AND IS NOT TO BE  
 REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY  
 MEANS, ELECTRONIC OR MECHANICAL, INCLUDING  
 PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION  
 STORAGE AND RETRIEVAL SYSTEM, WITHOUT  
 PERMISSION OF THE UNITED STATES OF AMERICA  
 (A)

INTERMOUNTAIN POWER  
 AGENCY  
 LAP-4102  
 STEAM GENERATOR UNIT-3  
 LYNNDYLL, UTAH  
 BABCOCK & WILCOX CO.  
 ORDER NO. 336642 CONT. NO. PB-

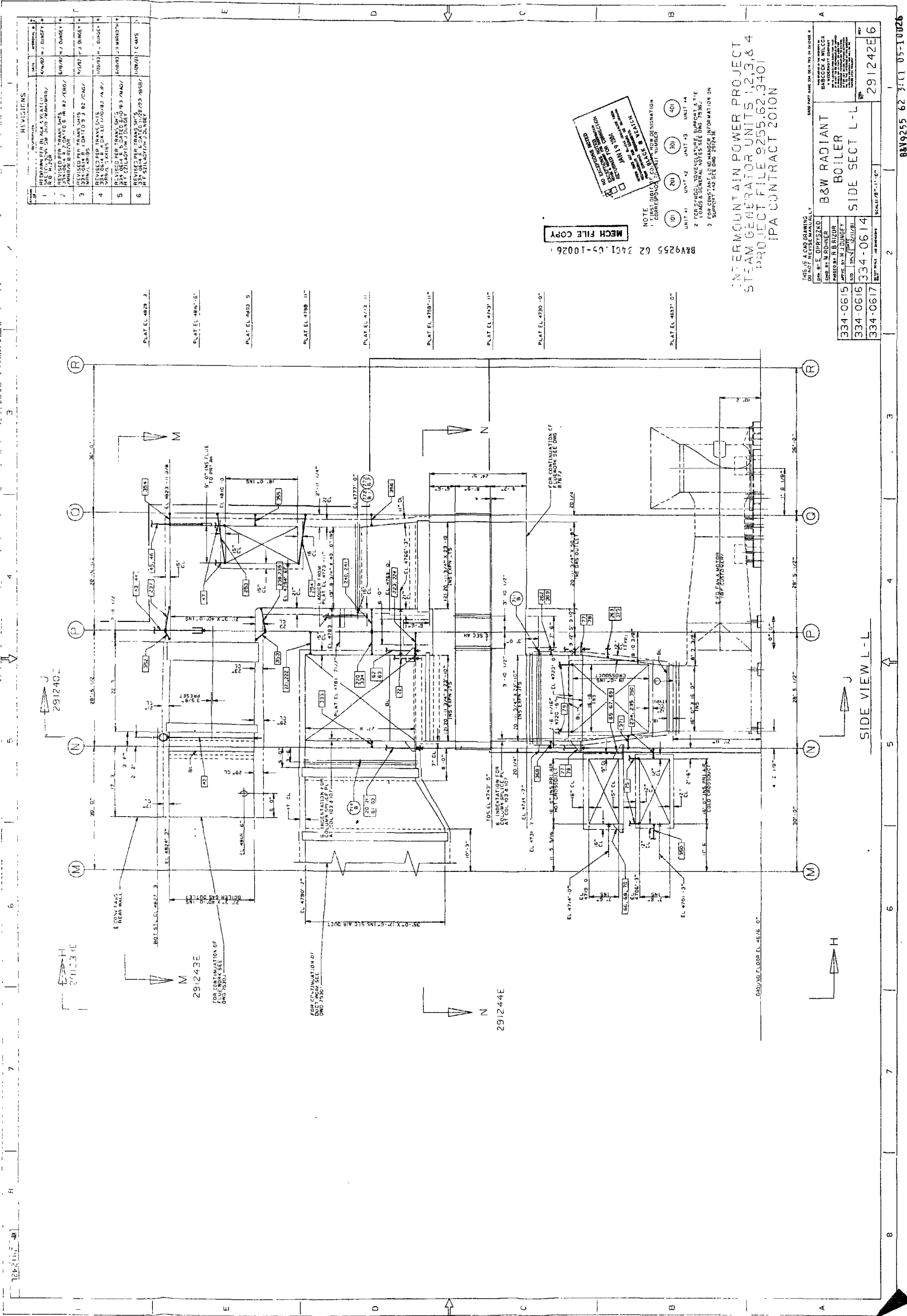
MOTOR DRIVE SECONDARY  
ON OF OPERATION. CUST TAG N  
(A) WHERE X IS THE A  
(E) (IV-351)  
INTERMOUNTAIN POWER  
AGENCY  
LAP-4100  
STEAM GENERATOR UNIT-2  
LYNNOLY, UTAH  
BABCOK & WILCOX CO.  
ORDER NO. 3.36621 CONT. NO. RB-

[illegible]

9255.62-3401.05-10039

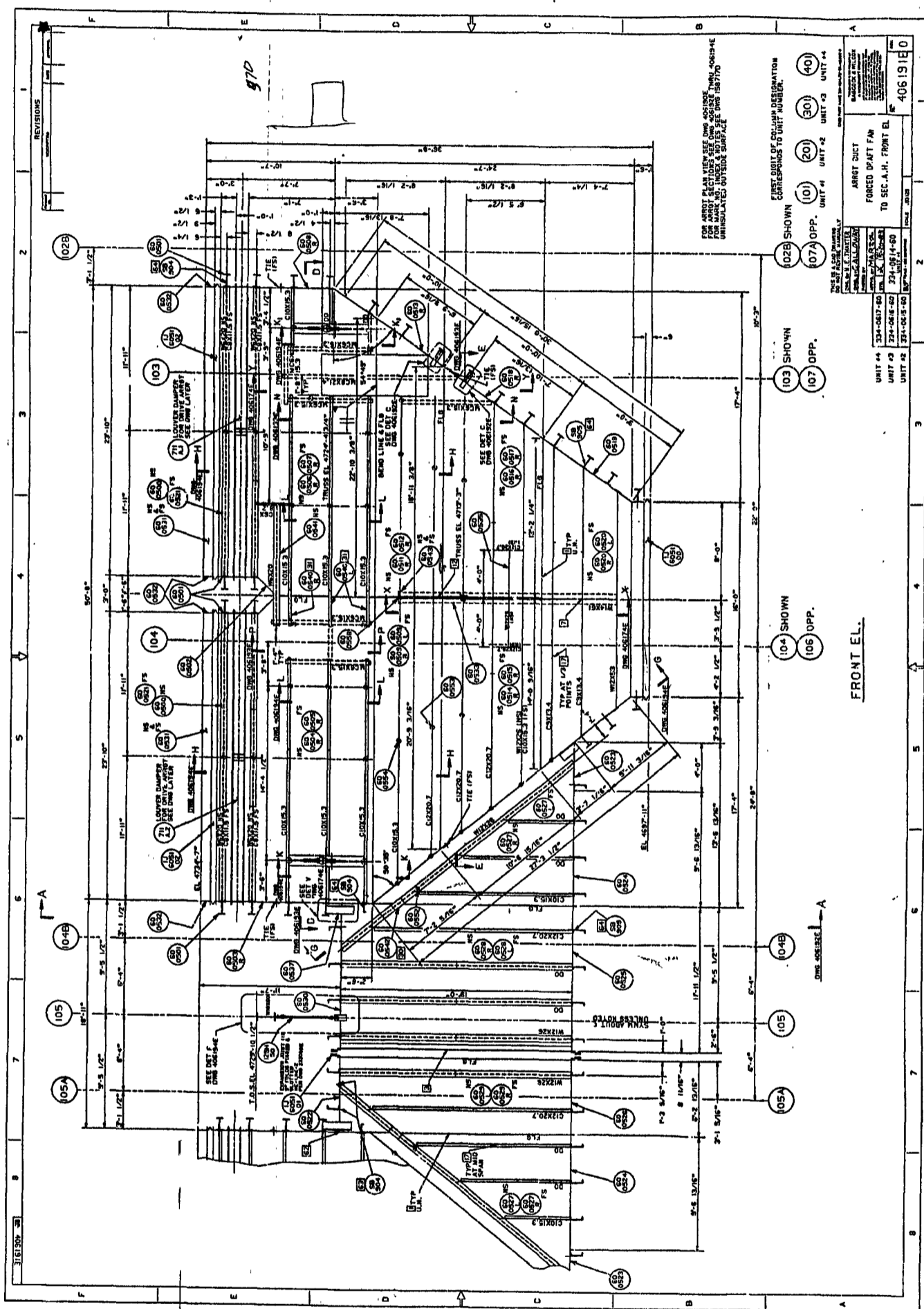






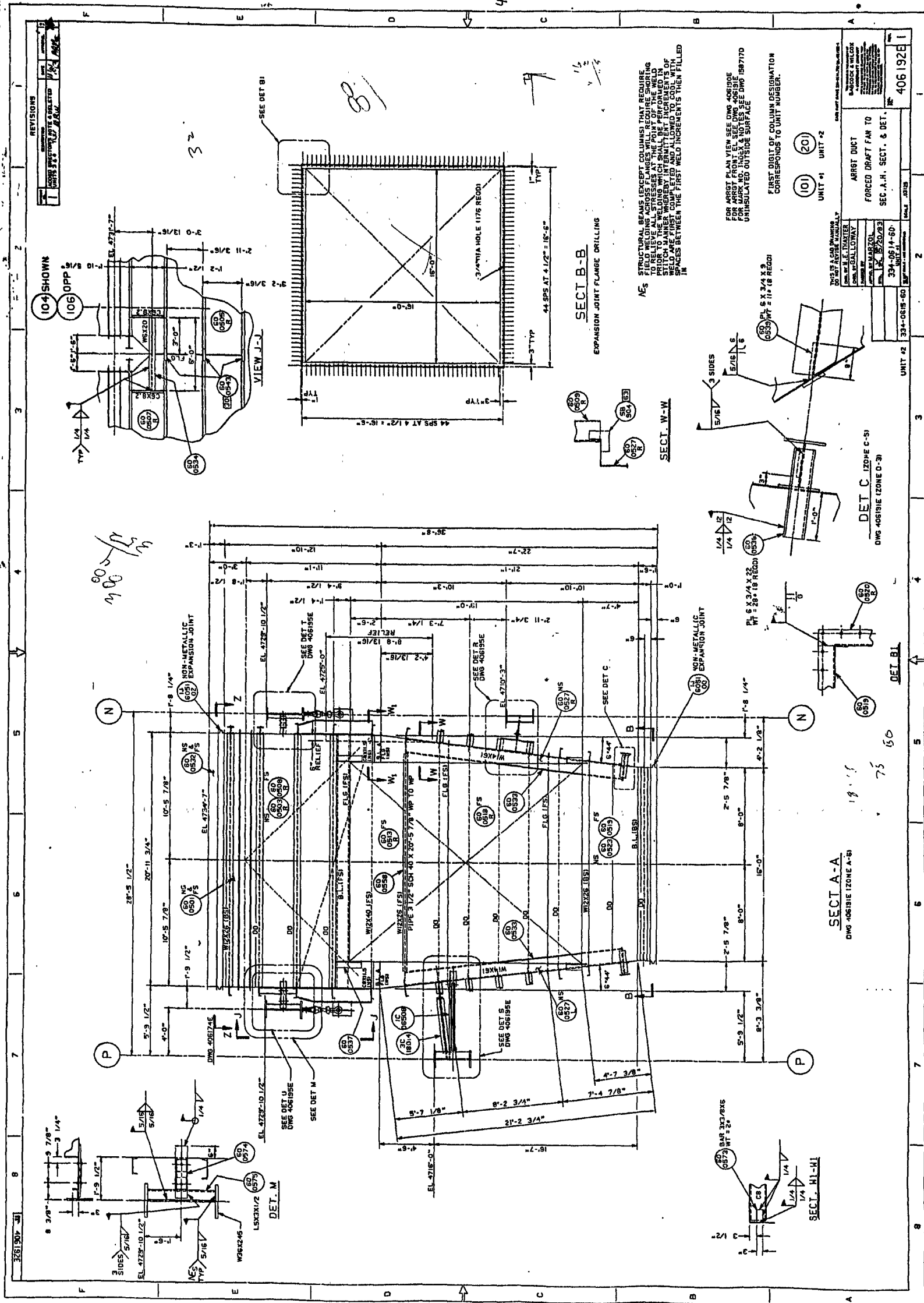
88V9255 62 3101 05-10026

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21  
22  
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24

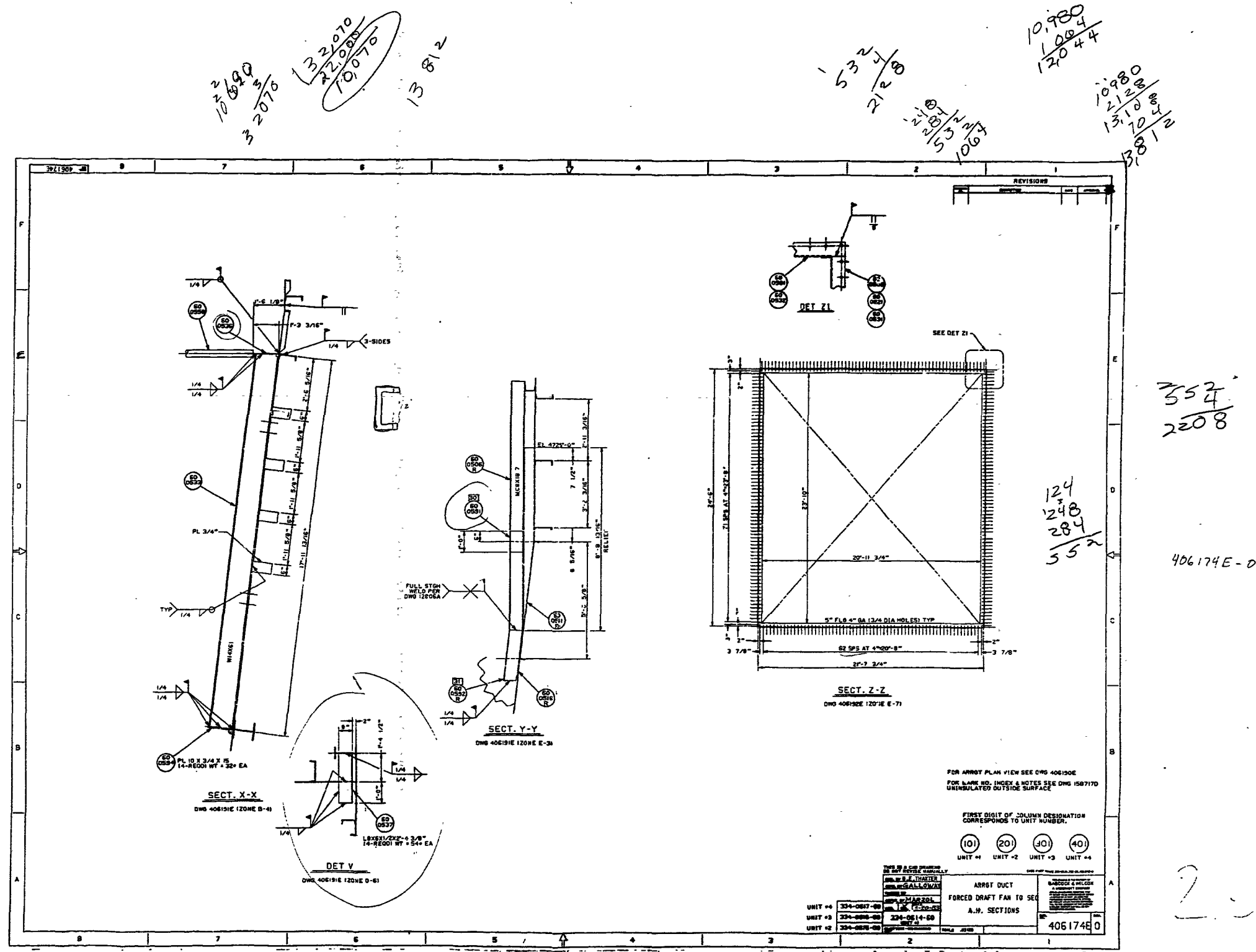


FRONT EL.

22





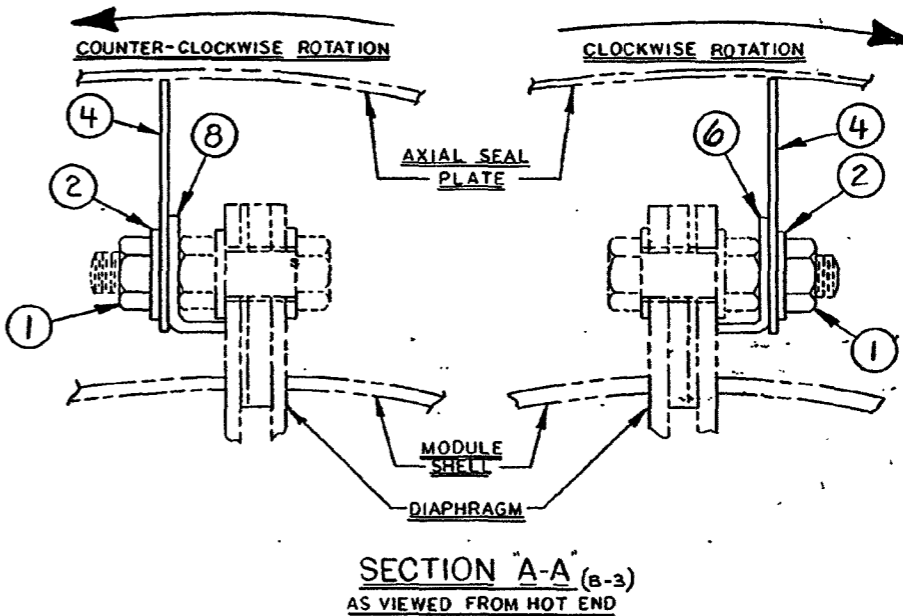
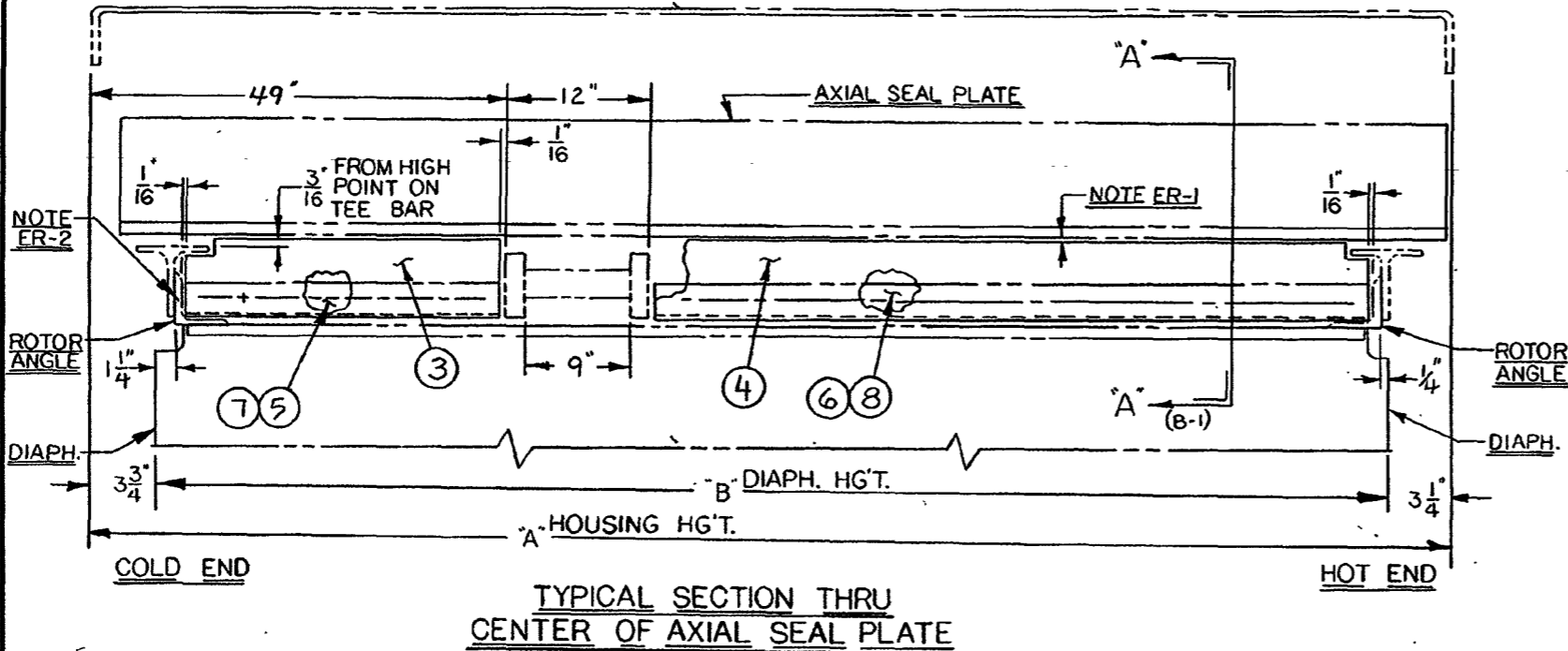




TABULATION										
ASS'Y. REQ'D.	ASS'Y. NO.	TAB "A"	TAB "B"	TAB "C"	TAB "E"	TAB "F"	TAB "G"	TAB "H"	APPROX. WGT.	ASS'Y. REQ'D.
	1	105"	98"	336	1	2	7	8		
	2									
	3									

BILL OF MATERIAL						
REF. NO.	PART CODE NO.	DRAWING NO.	REQ'D.	MAT'L.	DESCRIPTION	LOFT
1	32050	P-12-25412	"C"	3205	3/4" FIN. HEX. NUT	SL
2	32140	P-12-25413	"C"	3214	3/4" WASHER	SL
3		D-E-78076	24		AXIAL SEAL LEAF (COLD END)	SL
4		D-F-78076	24		AXIAL SEAL LEAF (HOT END)	SL
THE FOLLOWING TO BE FOR CLOCKWISE ROTATION						
5		D-G-76118	24		FORMED HOLDING STRIP (COLD END)	SL
6		D-H-76117	24		FORMED HOLDING STRIP (HOT END)	SL
THE FOLLOWING TO BE FOR COUNTER-CLOCKWISE ROTATION						
7		D-G-76117	24		FORMED HOLDING STRIP (COLD END)	SL
8		D-H-76118	24		FORMED HOLDING STRIP (HOT END)	SL

NOTES TO ERECTOR:  
 ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106.  
 ER-2 NOTCH FORMED HOLDING STRIP TO FIT AT ASSEMBLY.



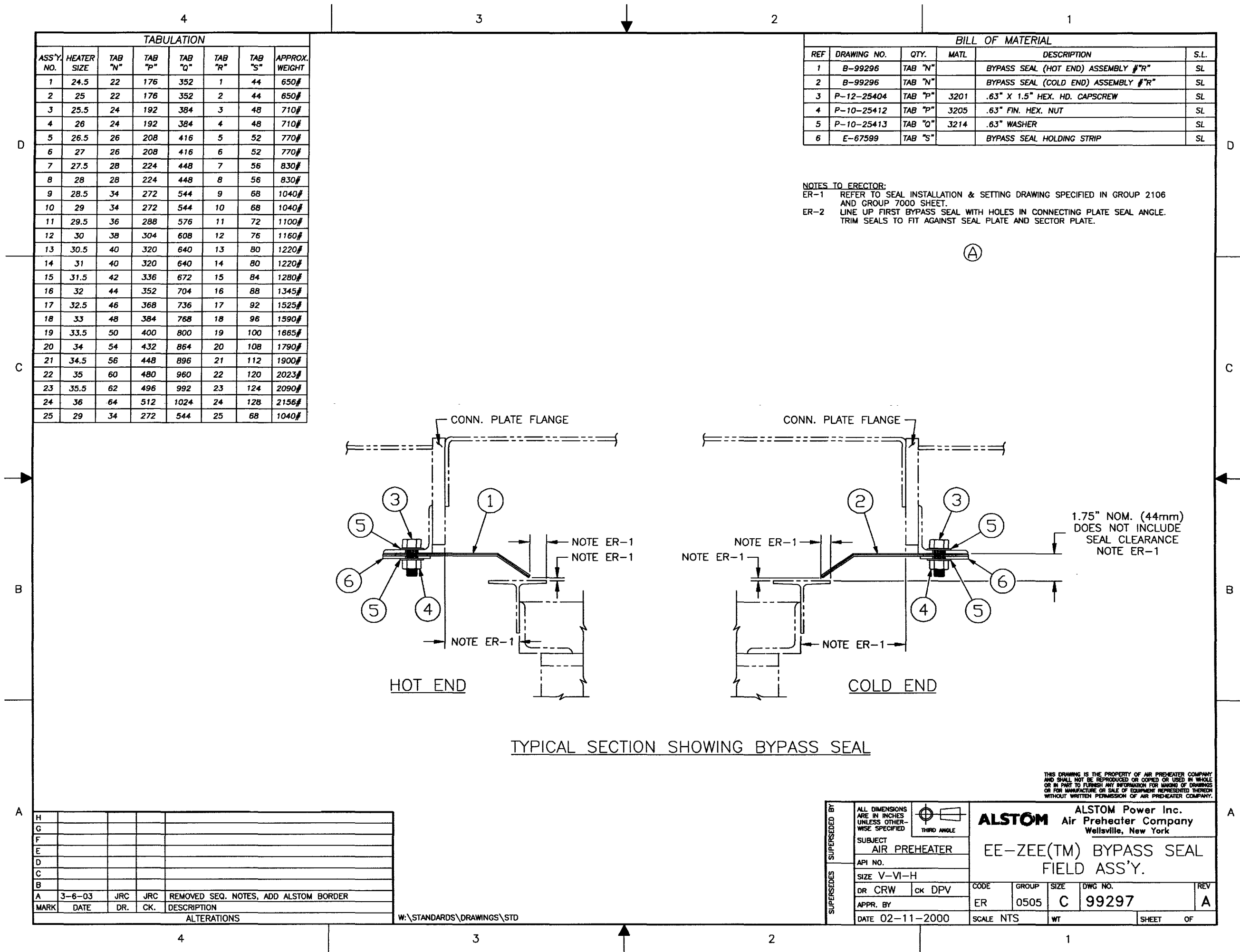
2 LAYER SIDE REMOVAL - DEF. SECTOR PL.

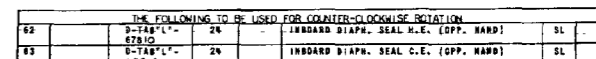
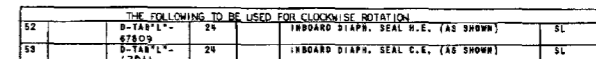
J			
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MARK	DATE	ALT.	CKD.
ALTERATIONS			

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SUPERSEDED BY	Subject		PROCESS EQUIPMENT		AXIAL SEAL ASSEMBLY			
	AIR PREHEATER		CE AIR PREHEATER WELLSVILLE, NEW YORK		9"-CLEAR PIN LENGTH			
SUPERSEDES	Model / Part		Des.		DRAWING NUMBER			
	MOD.		Ch. DV		GROUP SIZE NUMBER ISSUE			
	Dr. KAT		Ch. DV		ER 80100			
	Tr.		Ch.		0504 C 78075			
	Material				WT. SHEET OF			
	Stk. No.		DATE 3-15-83		SCALE NTS			

IP7\_033913





NOTES TO DIRECTOR:

1. INSTALL ALL BOLTS, NUTS AND WASHERS TO BE INSTALLED EXACTLY AS SHOWN.

2. HOLE IN END OF "C" BAR FOR INSTALLATION AND SETTING DRAWING". GROUP 2103

3. END OR END DETERMINE HIGHEST DIAPHRAGM, MEASURE DISTANCE FROM CENTER OF OUTWARD RADIAL SEAL TO HOLE TO MACHINED SURFACE OF SECTOR PLATE ON TO STRAIGHT RIG

4. END SUBTRACT "2" FROM DISTANCE MEASURED IN STEP 3. DISTANCE REMAINING = SUPPORT ANGLE TO THIS DIM. FROM COLD END OF SAME DIAPHRAGM, MEASURE DISTANCE FROM CENTER OF OUTWARD RADIAL SEAL TO MACHINED SURFACE OF SECTOR PLATE 90 TO STRAIGHT EDGE. SUBTRACT "2" FROM THIS DIM. & SET SUPPORT ANGLE TO THIS DIM. (NOTE: VARIATION BETWEEN CONNECTING PL. TO HOUSING SPILL THE "T" BAR SUPPORT ANGLE NOT EXCEED 1/8")

5. END AFTER SUPPORT ANGLE ARE SET & WELDED IN PLACE, INSTALL ALL OF SPACERS (LOC. TO F) FROM REF. 91, 92, 93, 94, 95

6. END FROM REF. 91, 92, 93, 94, 95 TO 92, 93, 94 WITH ENDS LOCATED ON CENTER LINES OF HOUSINGS TO THE RADIOUS SHOWN NOT EXCEEDING A TOTAL VARIATION OF 1/8".

7. END "T" BAR TO SUPPORT ANGLE. INSTALL "T" BAR TO SUPPORT ANGLE. INSTALL "T" BAR TO SUPPORT ANGLE. INSTALL "T" BAR TO SUPPORT ANGLE.


8. END INSTALL ROSTER POST STALLS, REF. 96, 96A TO CLEARANCE DIMENSION SHOWN & WELD AS SHOWN IN VIEW "A-B"

9. END RECOMMENDED PROCEDURE FOR INSTALLING RADIAL SEALS:

1.1 STARTING AT OUTWARD ENDS, LOCATE DIAPHR. SPACER WITH SPACER HOLES CENTERED ON DIAPHR. TAIL END OF DIAPHR. SPACER HOLES TO BE LOCATED ON DIAPHR. SPACER HOLES INSET BOLTS, REF. 91 & 90, WITH WASHER REF. 96 & 93, & DIAPHR. SEAL REF. 91 & 90, ON BOLT. INSTALL RADIAL SEAL LEAF SECTION FOLLOWED BY RADIAL SEAL TAIL END. WELD TO HOUSING. REPEAT THIS PROCEDURE FOR EACH DIAPHR. SPACER. REF. 91 & 92, WITHOUT TIGHTENING. INSTALL REF. 91, 92, 93, 94, 95 & 96 IN THEIR PROPER LOCATIONS. TIGHTEN 91, 92, 93, 94, 95, 96, 96A, 96B, 96C, 96D, 96E, 96F, 96G, 96H, 96I, 96J, 96K, 96L, 96M, 96N, 96O, 96P, 96Q, 96R, 96S, 96T, 96U, 96V, 96W, 96X, 96Y, 96Z, 96AA, 96AB, 96AC, 96AD, 96AE, 96AF, 96AG, 96AH, 96AI, 96AJ, 96AK, 96AL, 96AM, 96AN, 96AO, 96AP, 96AQ, 96AR, 96AS, 96AT, 96AU, 96AV, 96AW, 96AX, 96AY, 96AZ, 96BA, 96BB, 96BC, 96BD, 96BE, 96BF, 96BG, 96BH, 96BI, 96BJ, 96BK, 96BL, 96BM, 96BN, 96BO, 96BP, 96BQ, 96BR, 96BS, 96BT, 96BU, 96BV, 96BW, 96BX, 96BY, 96BZ, 96CA, 96CB, 96CC, 96CD, 96CE, 96CF, 96CG, 96CH, 96CI, 96CJ, 96CK, 96CL, 96CM, 96CN, 96CO, 96CP, 96CQ, 96CR, 96CS, 96CT, 96CU, 96CV, 96CW, 96CX, 96CY, 96CZ, 96DA, 96DB, 96DC, 96DD, 96DE, 96DF, 96DG, 96DH, 96DI, 96DJ, 96DK, 96DL, 96DM, 96DN, 96DO, 96DP, 96DQ, 96DR, 96DS, 96DT, 96DU, 96DV, 96DW, 96DX, 96DY, 96DZ, 96EA, 96EB, 96EC, 96ED, 96EE, 96EF, 96EG, 96EH, 96EI, 96EJ, 96EK, 96EL, 96EM, 96EN, 96EO, 96EP, 96EQ, 96ER, 96ES, 96ET, 96EU, 96EV, 96EW, 96EX, 96EY, 96EZ, 96FA, 96FB, 96FC, 96FD, 96FE, 96FF, 96FG, 96FH, 96FI, 96FJ, 96FK, 96FL, 96FM, 96FN, 96FO, 96FP, 96FQ, 96FR, 96FS, 96FT, 96FU, 96FV, 96FW, 96FX, 96FY, 96FZ, 96GA, 96GB, 96GC, 96GD, 96GE, 96GF, 96GG, 96GH, 96GI, 96GJ, 96GK, 96GL, 96GM, 96GN, 96GO, 96GP, 96GQ, 96GR, 96GS, 96GT, 96GU, 96GV, 96GW, 96GX, 96GY, 96GZ, 96HA, 96HB, 96HC, 96HD, 96HE, 96HF, 96HG, 96HH, 96HI, 96HJ, 96HK, 96HL, 96HM, 96HN, 96HO, 96HP, 96HQ, 96HR, 96HS, 96HT, 96HU, 96HV, 96HW, 96HX, 96HY, 96HZ, 96IA, 96IB, 96IC, 96ID, 96IE, 96IF, 96IG, 96IH, 96II, 96IJ, 96IK, 96IL, 96IM, 96IN, 96IO, 96IP, 96IQ, 96IR, 96IS, 96IT, 96IU, 96IV, 96IW, 96IX, 96IY, 96IZ, 96JA, 96JB, 96JC, 96JD, 96JE, 96JF, 96JG, 96JH, 96JI, 96JJ, 96JK, 96JL, 96JM, 96JN, 96JO, 96JP, 96JQ, 96JR, 96JS, 96JT, 96JU, 96JV, 96JW, 96JX, 96JY, 96JZ, 96KA, 96KB, 96KC, 96KD, 96KE, 96KF, 96KG, 96KH, 96KI, 96KJ, 96KL, 96KM, 96KN, 96KO, 96KP, 96KQ, 96KR, 96KS, 96KT, 96KU, 96KV, 96KW, 96KX, 96KY, 96KZ, 96LA, 96LB, 96LC, 96LD, 96LE, 96LF, 96LG, 96LH, 96LI, 96LJ, 96LK, 96LL, 96LM, 96LN, 96LO, 96LP, 96LQ, 96LR, 96LS, 96LT, 96LU, 96LV, 96LW, 96LX, 96LY, 96LZ, 96MA, 96MB, 96MC, 96MD, 96ME, 96MF, 96MG, 96MH, 96MI, 96MJ, 96MK, 96ML, 96MN, 96MO, 96MP, 96MQ, 96MR, 96MS, 96MT, 96MU, 96MV, 96MW, 96MX, 96MY, 96MZ, 96NA, 96NB, 96NC, 96ND, 96NE, 96NF, 96NG, 96NH, 96NI, 96NJ, 96NK, 96NL, 96NM, 96NO, 96NP, 96NQ, 96NR, 96NS, 96NT, 96NU, 96NV, 96NW, 96NX, 96NY, 96NZ, 96OA, 96OB, 96OC, 96OD, 96OE, 96OF, 96OG, 96OH, 96OI, 96OJ, 96OK, 96OL, 96OM, 96ON, 96OO, 96OP, 96OQ, 96OR, 96OS, 96OT, 96OU, 96OV, 96OW, 96OX, 96OY, 96OZ, 96PA, 96PB, 96PC, 96PD, 96PE, 96PF, 96PG, 96PH, 96PI, 96PJ, 96PK, 96PL, 96PM, 96PN, 96PO, 96PP, 96PQ, 96PR, 96PS, 96PT, 96PU, 96PV, 96PW, 96PX, 96PY, 96PZ, 96QA, 96QB, 96QC, 96QD, 96QE, 96QF, 96QG, 96QH, 96QI, 96QJ, 96QK, 96QL, 96QM, 96QN, 96QO, 96QP, 96QQ, 96QR, 96QS, 96QT, 96QU, 96QV, 96QW, 96QX, 96QY, 96QZ, 96RA, 96RB, 96RC, 96RD, 96RE, 96RF, 96RG, 96RH, 96RI, 96RJ, 96RK, 96RL, 96RM, 96RN, 96RO, 96RP, 96RQ, 96RR, 96RS, 96RT, 96RU, 96RV, 96RW, 96RX, 96RY, 96RZ, 96SA, 96SB, 96SC, 96SD, 96SE, 96SF, 96SG, 96SH, 96SI, 96SJ, 96SK, 96SL, 96SM, 96SN, 96SO, 96SP, 96SQ, 96SR, 96SS, 96ST, 96SU, 96SV, 96SW, 96SX, 96SY, 96SZ, 96TA, 96TB, 96TC, 96TD, 96TE, 96TF, 96TG, 96TH, 96TI, 96TJ, 96TK, 96TL, 96TM, 96TN, 96TO, 96TP, 96TQ, 96TR, 96TS, 96TT, 96TU, 96TV, 96TW, 96TX, 96TY, 96TZ, 96UA, 96UB, 96UC, 96UD, 96UE, 96UF, 96UG, 96UH, 96UI, 96UJ, 96UK, 96UL, 96UM, 96UN, 96UO, 96UP, 96UQ, 96UR, 96US, 96UT, 96UU, 96UV, 96UW, 96UX, 96UY, 96UZ, 96VA, 96VB, 96VC, 96VD, 96VE, 96VF, 96VG, 96VH, 96VI, 96VJ, 96VK, 96VL, 96VM, 96VN, 96VO, 96VP, 96VQ, 96VR, 96VS, 96VT, 96VU, 96VV, 96VW, 96VX, 96VY, 96VZ, 96WA, 96WB, 96WC, 96WD, 96WE, 96WF, 96WG, 96WH, 96WI, 96WJ, 96WK, 96WL, 96WM, 96WN, 96WO, 96WP, 96WQ, 96WR, 96WS, 96WT, 96WU, 96WV, 96WW, 96WX, 96WY, 96WZ, 96XA, 96XB, 96XC, 96XD, 96XE, 96XF, 96XG, 96XH, 96XI, 96XJ, 96XK, 96XL, 96XM, 96XN, 96XO, 96XP, 96XQ, 96XR, 96XS, 96XT, 96XU, 96XV, 96XW, 96XX, 96XY, 96XZ, 96YA, 96YB, 96YC, 96YD, 96YE, 96

THIS DRAWING IS THE PROPERTY OF THE AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE AIR PREHEATER COMPANY.

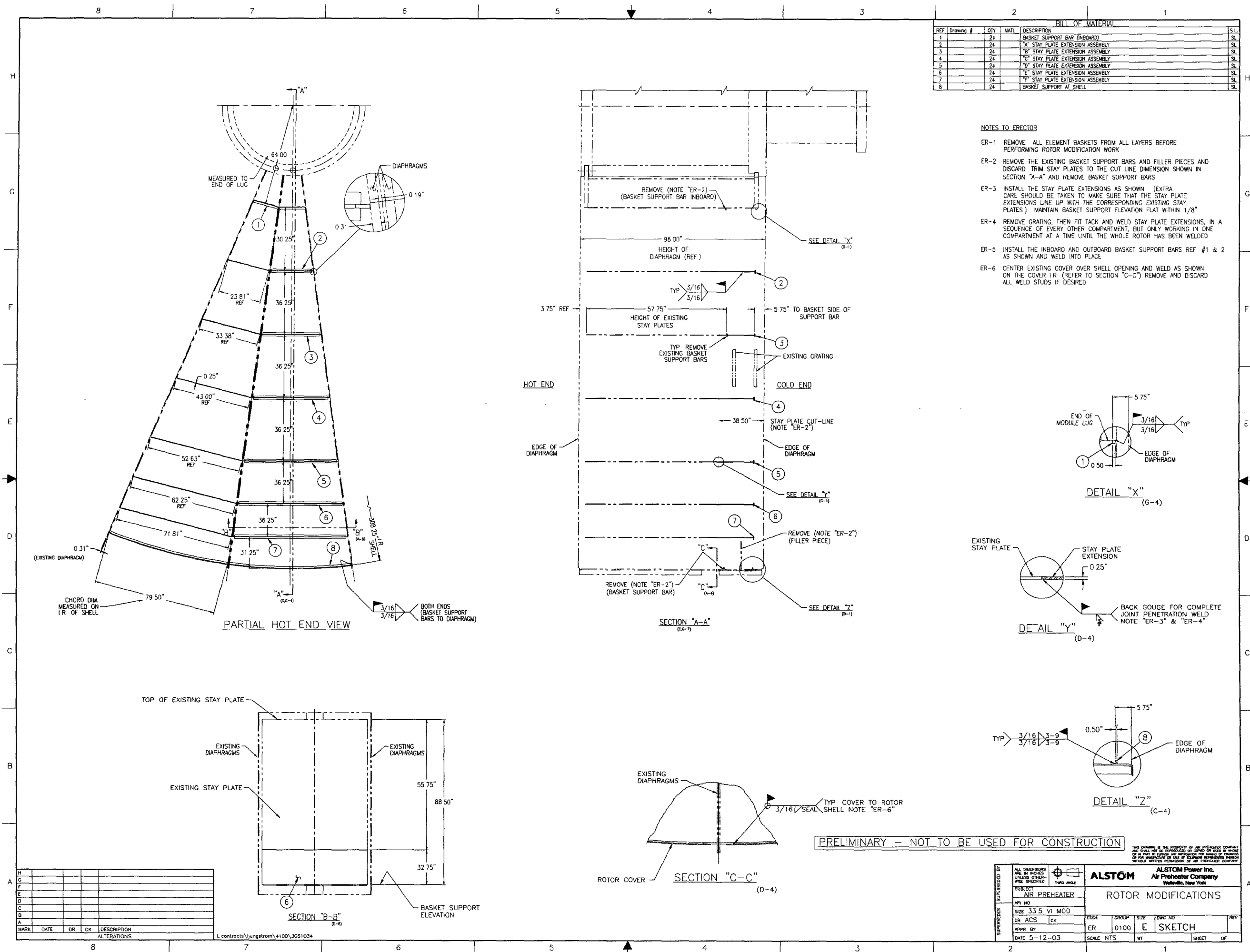
LAS. COLD END -- DEF. SECT PL's.

SUPERSEDED BY	Subject	AIR PREHEATER		 <b>AIR PREHEATER</b> <small>Q3 AIR PREHEATER WILLIAMSBURG, NEW YORK</small>
	Model /	MOD		
	Serial Type	3-2 1/2 - 53-1/2 VI		
	Part	Ch.		
	Draw. MAT	Ch.	6V	
SUPERSEDED	Tr.	Ch.		
	Material			
	Ch. No.			

Rev. 9-16-63 ACAC:MTS

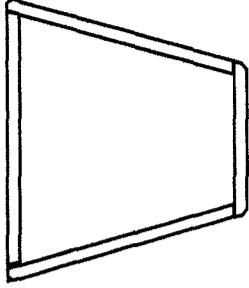
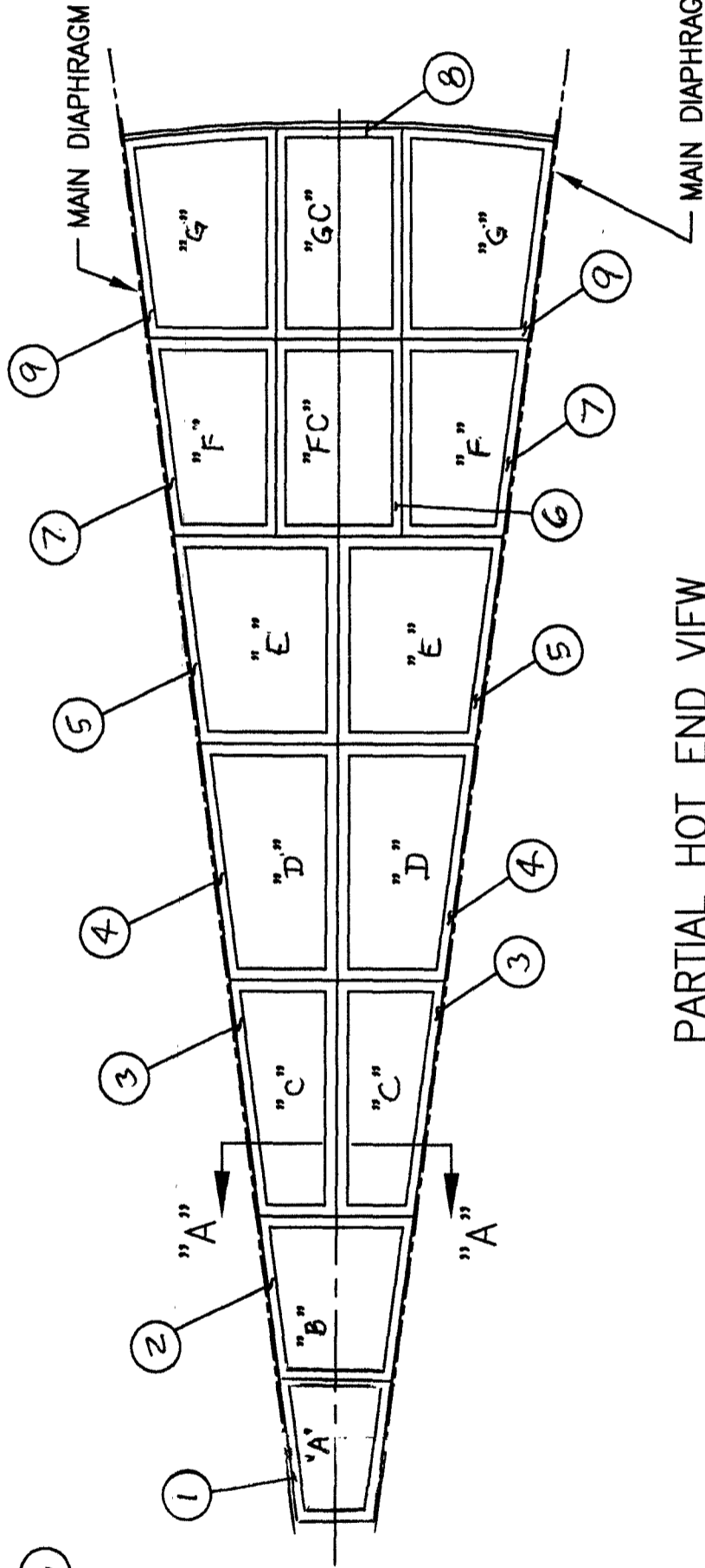
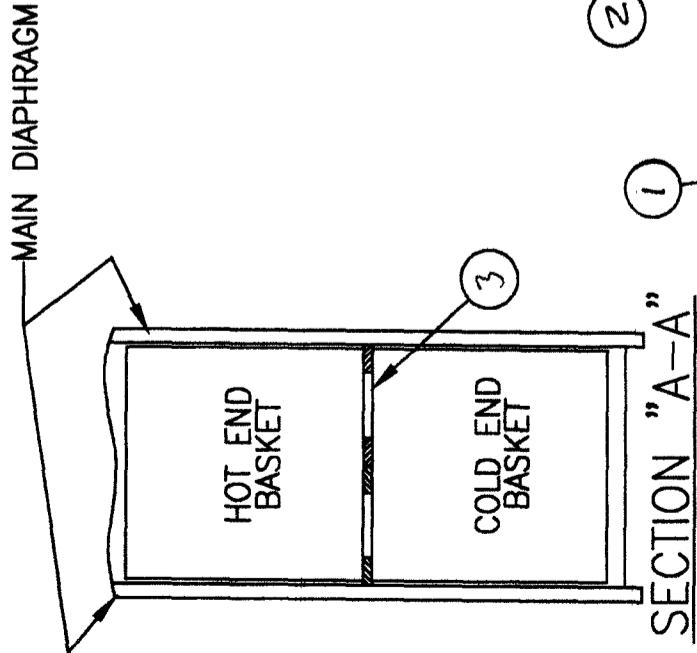
DRAWING NUMBER				
Q3509	GROUP	SIZE	NUMBER	ISS
ER	0103	H	78077	A
WT.	ASST	MP		





NOTES TO ERECTOR:

- ER-1) AFTER INSTALLING COLD END BASKETS, INSTALL SEALING BAR ASSEMBLIES BETWEEN HOT AND COLD END BASKETS. DO NOT WELD IN PLACE.
- ER-2) SEALS ARE DESIGNED TO FIT TIGHTLY IN EACH COMPARTMENT IT MAY BE NECESSARY TO SLIDE THE SEAL DOWN AGAINST THE DIAPHRAGM VERTICALLY OR TO ANGLE THE SEAL INTO PLACE. TRIM SEALS TO FIT COMPARTMENT ONLY AS LAST OPTION.
- ER-3) INSTALL HOT END BASKETS.



TYPICAL "A" BASKET SEAL ASS'Y

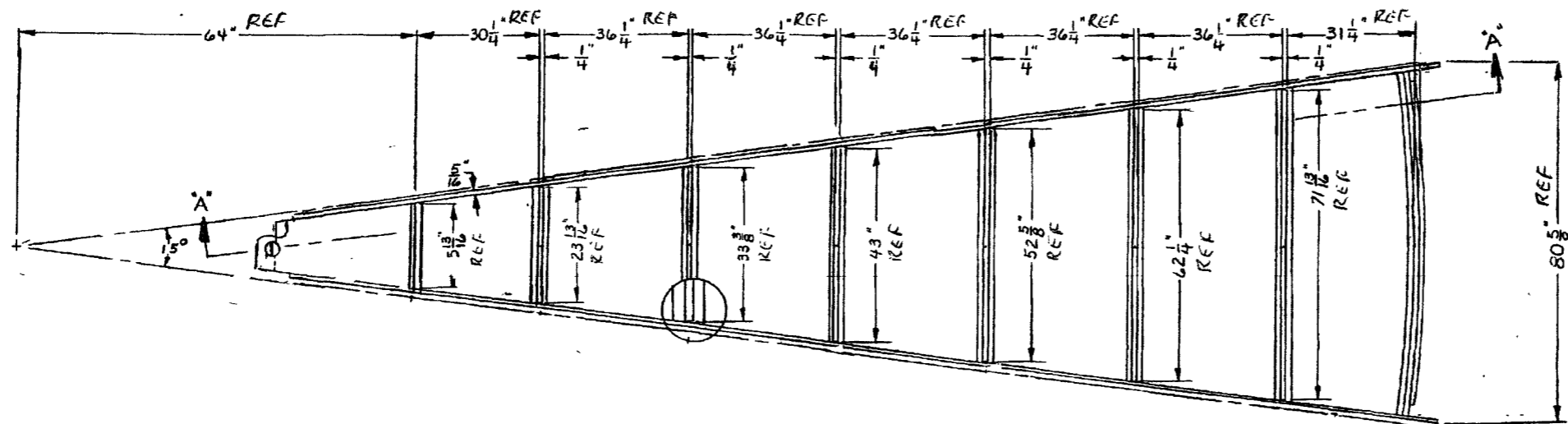
PARTIAL HOT END VIEW

THIS DRAWING IS THE PROPERTY OF ABB AIR PREHEATER, INC. AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE ABB AIR PREHEATER, INC.

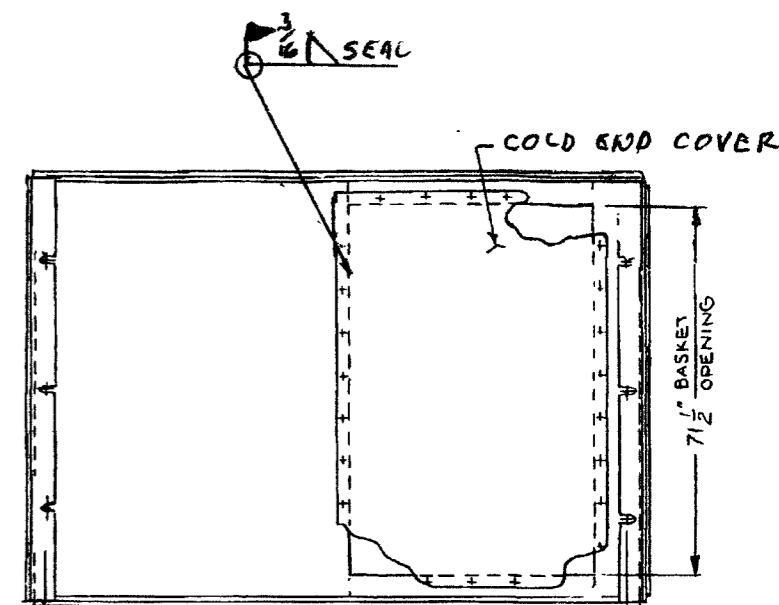
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G						
F						
E						
D						
C						
B						
A						
MARK	DATE	DR.	CK.	ALTERATIONS		
COMMENTS						

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		THIRD ANGLE		ABB AIR PREHEATER, INC. WELLSVILLE, NEW YORK	
SUBJECT AIR PREHEATER		GROUP		BASKET SEALING BAR INSTALLATION	
API NO.		SIZE		DWG NO.	
SIZE 33-1/2 VI		0204		D SK-010513	
DR CK		CODE ER		REV	
APPR. BY		SCALE NTS		SHEET OF	
DATE 5/13/03		WT			

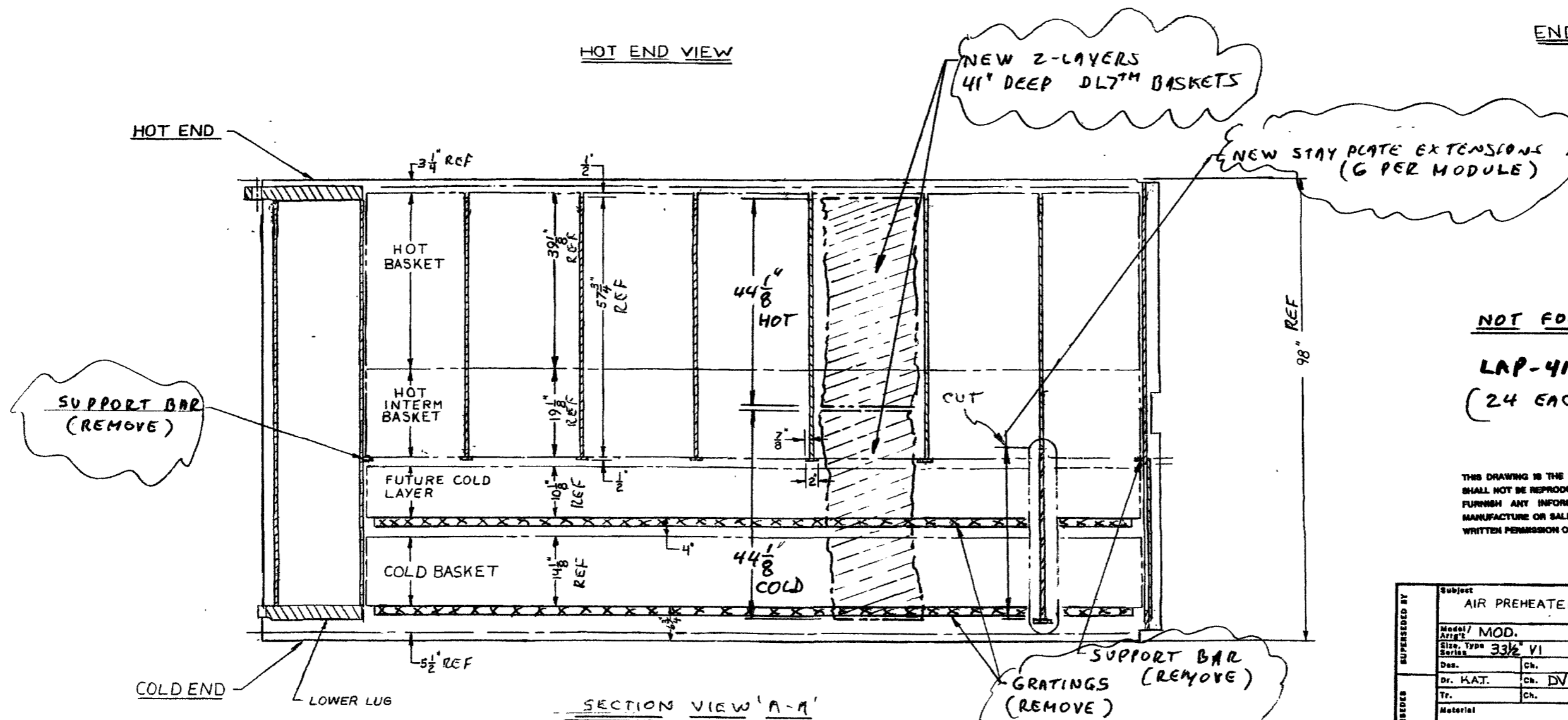
REF. NO.	REQ'D.	DESCRIPTION	SL
1	24	"A" BASKET SEALING BAR ASSEMBLY	SL
2	24	"B" BASKET SEALING BAR ASSEMBLY	SL
3	48	"C" BASKET SEALING BAR ASSEMBLY	SL
4	48	"D" BASKET SEALING BAR ASSEMBLY	SL
5	48	"E" BASKET SEALING BAR ASSEMBLY	SL
6	24	"FC" BASKET SEALING BAR ASSEMBLY	SL
7	48	"F" BASKET SEALING BAR ASSEMBLY	SL
8	24	"GC" BASKET SEALING BAR ASSEMBLY	SL
9	48	"G" BASKET SEALING BAR ASSEMBLY	SL



HOT END VIEW



END VIEW




SECTION VIEW 'A-A'

NOT FOR CONSTRUCTION

**LAP-4100 EXISTING MODULE**  
(24 EACH AH ROTOR)

THIS DRAWING IS THE PROPERTY OF THE AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE AIR PREHEATER COMPANY.

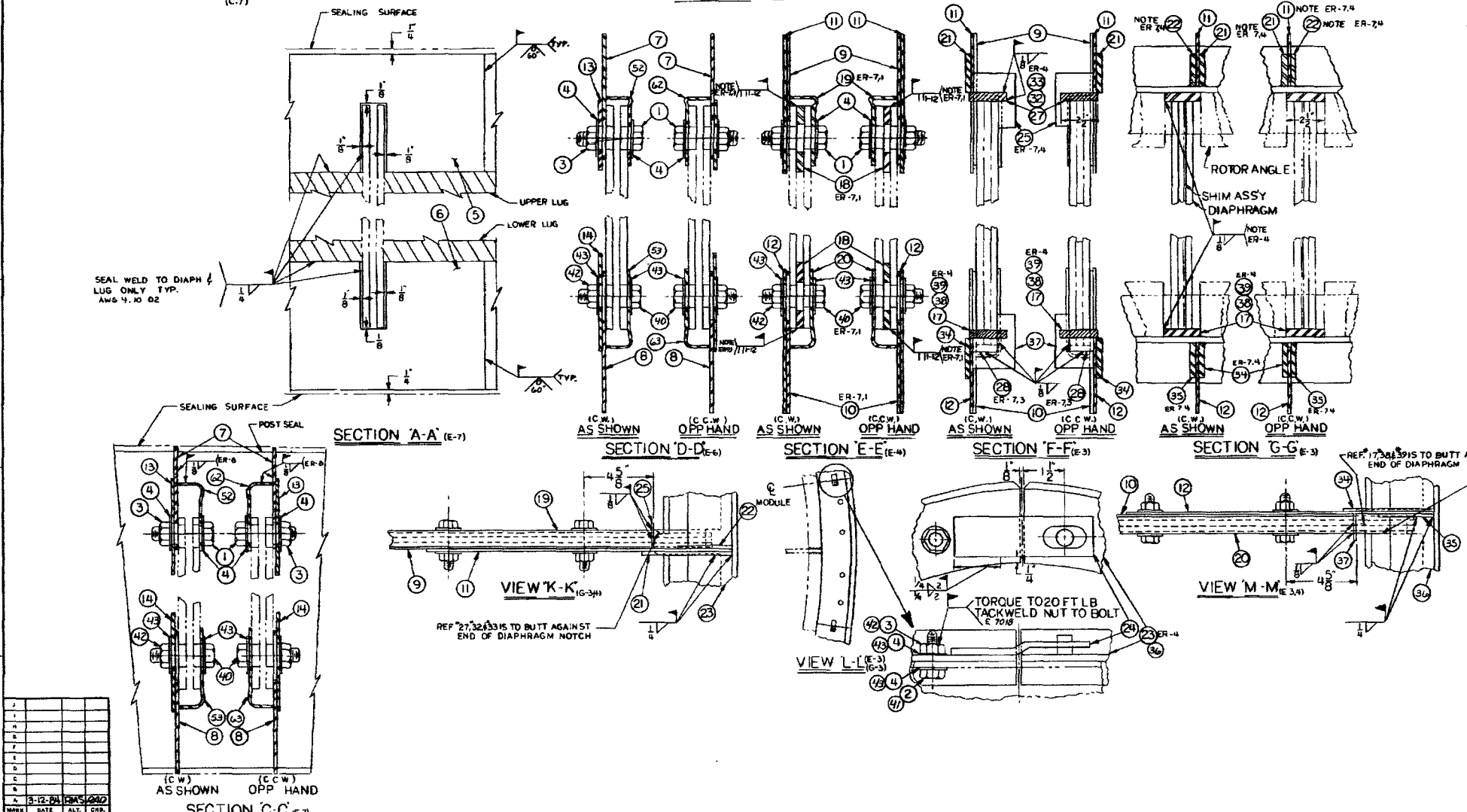
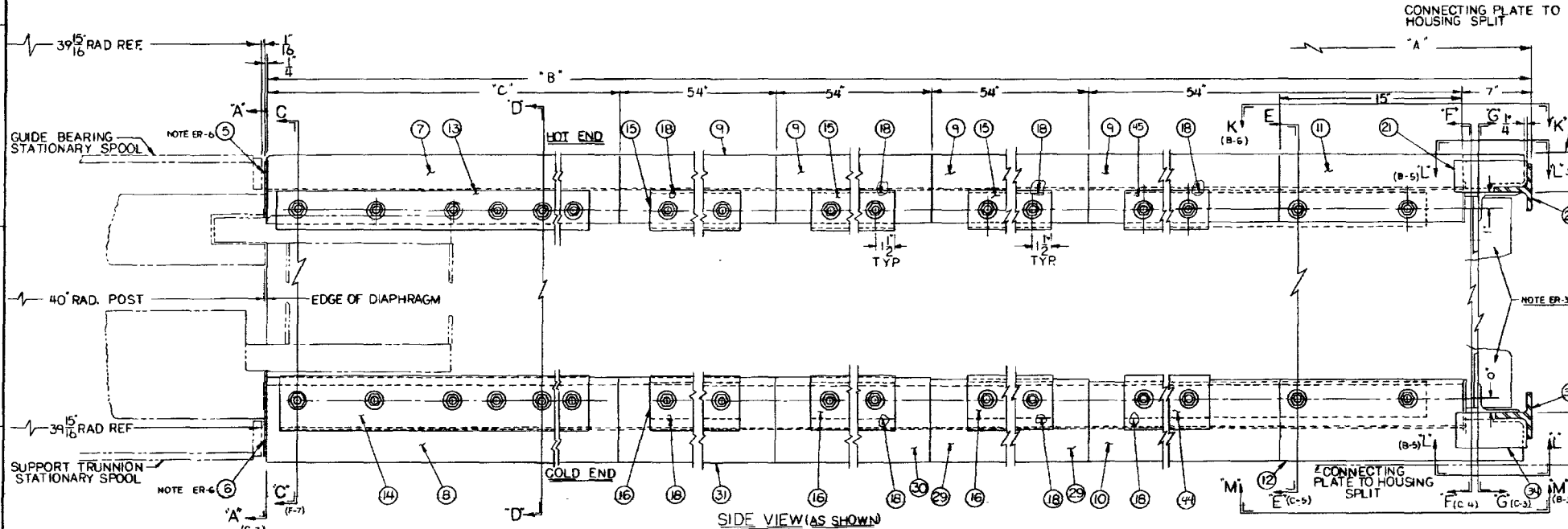
SUPERSEDED BY	Subject	AIR PREHEATER		 <b>PROCESS EQUIPMENT</b> CE AIR PREHEATER WELLSVILLE, NEW YORK
	Model / Arr't	MOD.		
	Size, Type Series	33 1/2 VI		
	Des.	Ch.		
SUPERSEDED	Dr. K.A.T.	Ch. DV		MODULE ASSEMBLY  LAP-4100
	Tr.	Ch.		
	Material			
	Sth. No.			
	DATE 3-10-83	SCALE NTS		

CODES 80100 ER	DRAWING NUMBER			
	GROUP	SIZE	NUMBER	IS
	0108	A	935435	
	WT.	SHEET OF		

[illegible]

THE FOLLOWING TO BE USED FOR CLOCKWISE ROTATION					
52	D-7AB*1'- 67800	24		INBOARD DIAPH. SEAL W.E. (AS SHOWN)	SL
53	D-7AB*1'- 676+1	24		INBOARD DIAPH. SEAL C.E. (AS SHOWN)	SL

THE FOLLOWING TO BE USED FOR COUNTER-CLOCKWISE ROTATION				
62	D-TAB'L*- 87810	25	INBOARD DIAPH. SEAL H.E. (OPP. HAND)	SL
63	D-TAB'L*- 67812	25	INBOARD DIAPH. SEAL C.E. (OPP. HAND)	SL



NOT TO DIRECTOR

1. ALL BOLTS, NUTS AND WASHERS TO BE INSTALLED EXACTLY AS SHOWN.

2. FOLLOW ALL INSTRUCTIONS ON "SEAL INSTALLATION AND SETTING DRAWING", GROUP 5210.

3. DO NOT DETERMINE HIGHEST DIAPHRAGM, MEASURE DISTANCE FROM CENTER OF OUTWARD RADIAL MACHINERY TO HIGHEST DIAPHRAGM AND SET STRAIGHT EDGE, SUBTRACT "1" FROM THIS DIM. AND SET ALL NOTED "2" BAR SUPPORT ANGLES TO THIS DIM. FROM COLL OF ONE SIDE DIAPHRAGM, MEASURE DISTANCE FROM CENTER OF OUTWARD RADIAL MACHINERY TO HIGHEST SURFACE OF SECTION PLATE ON TO SEAL STRAIGHT EDGE, SUBTRACT "0" FROM THIS DIM., SET SUPPORT ANGLES TO THIS DIM., TOTAL VARIATION BETWEEN CONNECTING PLATE TO HOUSING SHALL BE "0" AND SUPPORT ANGLE NOT EXCEED "1/8".

4. FOR SUPPORT ANGLES ARE SET & WELDED IN PLACE, INSTALL ALL SET OF SPACERS (GUT TO FIT) BETWEEN SEALS, TIGHTEN ALL BOLTS TO SPECIFIED TORQUE.

5. INSTALL "2" BAR, REF. 23 & 26 WITH ENDS LOCATED ON CENTER LINES OF HOLES IN THE RADIAL SHOWN NOT EXCEEDING A TOTAL VARIATION OF "1/8". BOLT "2" BAR TO SUPPORT ANGLE, INSTALL "2" BAR TO SUPPORT ANGLE.

6. INSTALL ROTOR POST SEALS, REF. 5656 TO CLEARANCE DIMENSION SHOWN & NELD AS SHOWN IN DRAWING.

7. RECOMMENDED PROCEDURE FOR INSTALLING RADIAL SEALS:-

1. STARTING AT OUTWARD ENDS, LOCATE DIAPH. SPACER WITH SPACER HOLES CENTERED IN HOLES, TIGHTEN BOLTS, REF. #1 & 40, WITH WASHER REF. #8 & 30, DIAPH. SEAL, REF. #19 & 90, ON BOLT. INSTALL RADIAL SEAL SEPARATELY, TIGHTEN WITH REF. #23, #26, TIGHTEN & HOLD IN PLACE. TIGHTEN DIAPHRAGM SPACER WITH REF. #23, #26, DO NOT TIGHTENING. INSTALL REF. #19, #40, #90, #42 & #43 IN THEIR PROPER LOCATIONS. TIGHTEN ALL BOLTS TO SPECIFIED TORQUE.

2. REPEAT THIS PROCEDURE FOR THE REMAINING SEAL LINE SECTIONS, TIGHTEN DIAPHRAGM SEALS TO FIT IT NEEDED.

7.2 AFTER SEALS ARE INSTALLED AND SET TO STRAIGHT EDGE, TIGHTEN BOLTS.


7.3 LOCATE REF. #28 & 37 AND NELD TO REF. #17, 19, 20, 22, 33, 35 & 39. LOCATE REF. #28 AND WELD AS SHOWN.

7.4 LOCATE REF. #21, 22, 34 & 35 AND NELD TO "2" BAR ONLY.

7.5 NELD REF. #21, 22, 34 & 35 TO STRAIGHT EDGE, MEASURE DIAPHRAGM SEAL REF. #19 & 90 (ALSO PUT 2 DOWN SIDE) TO POST SEAL AS SHOWN.

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LAS. COLD END → DEF. SECT PL's.

S E C U R I T Y	Subject <b>AIR PREHEATER</b>		 <b>AIR PRE-HEATER</b>		OR AIR PREHEATER MULTIPLE, AND VARI
	Model/ <b>MOD</b>		RADIAL SEAL ASS'Y. (5/16 DIAPH.)		
	Date Type <b>9-2-76 - 33-1/2 VI</b>				
	Size CA.				
S E C U R I T Y	Dr. <b>HXT</b>		DRAWING NUMBER 80507 GROUP SIZE NUMBER ISSUE <b>ER 0103 H 78077 A</b> BY: DATE DO		
	CA. <b>5V</b>				
	Tr. CA.				
	Material				
33-16-A3 MALINYS					

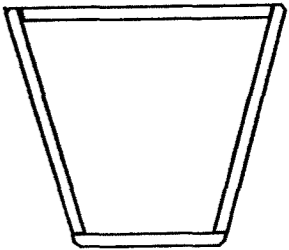
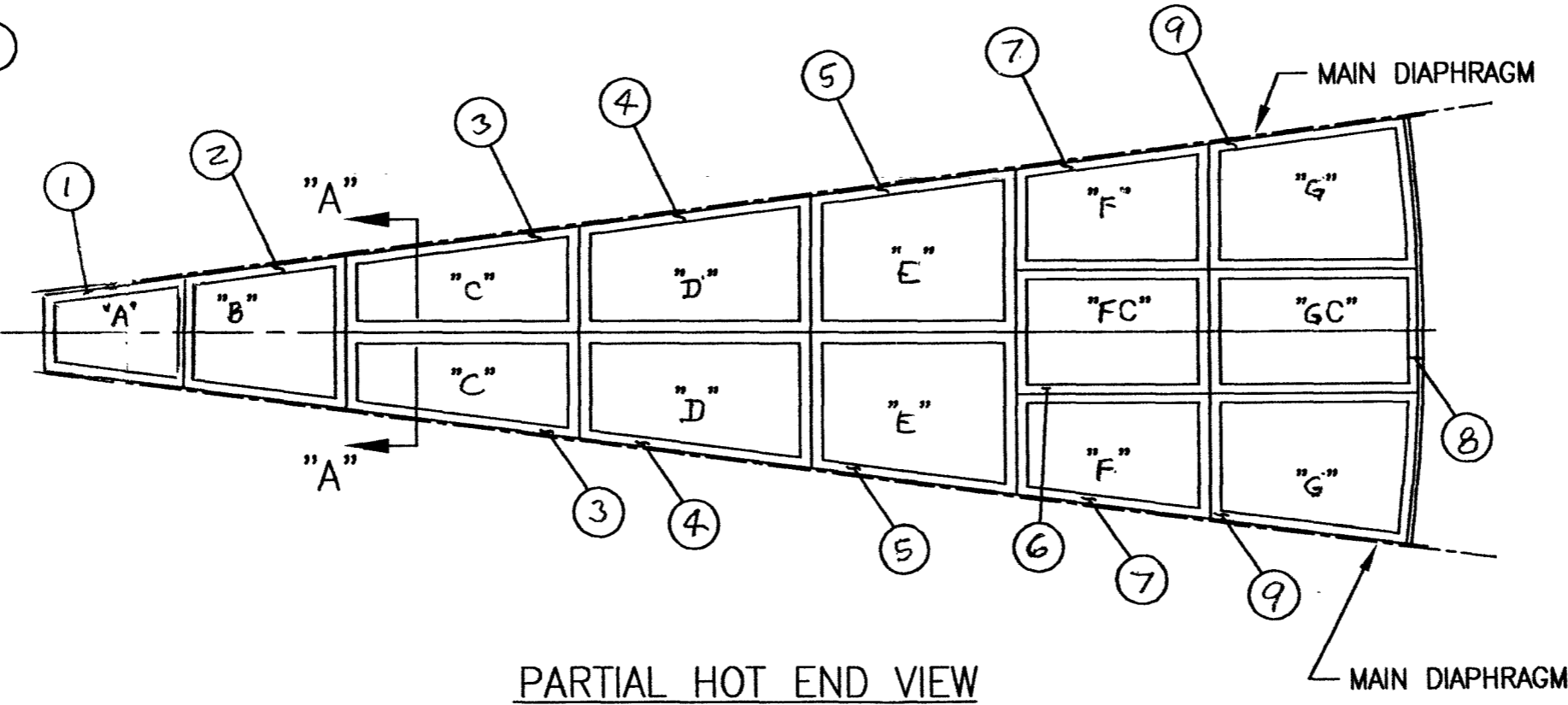
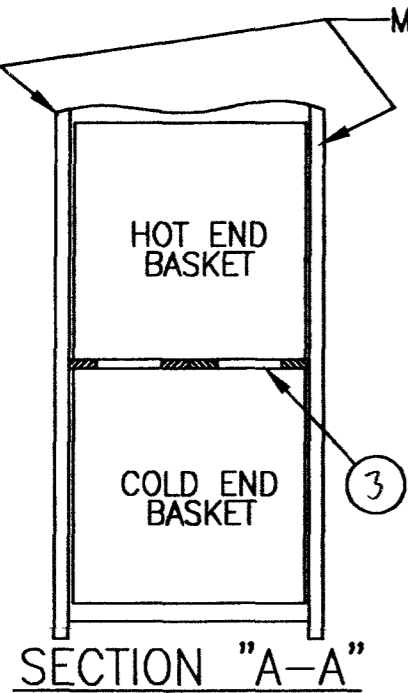
IP7\_033920

NOTES TO ERECTOR:

- ER-1) AFTER INSTALLING COLD END BASKETS, INSTALL SEALING BAR ASSEMBLIES BETWEEN HOT AND COLD END BASKETS. DO NOT WELD IN PLACE.
- ER-2) SEALS ARE DESIGNED TO FIT TIGHTLY IN EACH COMPARTMENT IT MAY BE NECESSARY TO SLIDE THE SEAL DOWN AGAINST THE DIAPHRAGM VERTICALLY OR TO ANGLE THE SEAL INTO PLACE. TRIM SEALS TO FIT COMPARTMENT ONLY AS LAST OPTION.
- ER-3) INSTALL HOT END BASKETS.

BILL OF MATERIAL

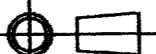
REF. NO.	REQ'D.	DESCRIPTION	SL
1	24	"A" BASKET SEALING BAR ASSEMBLY	SL
2	24	"B" BASKET SEALING BAR ASSEMBLY	SL
3	48	"C" BASKET SEALING BAR ASSEMBLY	SL
4	48	"D" BASKET SEALING BAR ASSEMBLY	SL
5	48	"E" BASKET SEALING BAR ASSEMBLY	SL
6	24	"FC" BASKET SEALING BAR ASSEMBLY	SL
7	48	"F" BASKET SEALING BAR ASSEMBLY	SL
8	24	"GC" BASKET SEALING BAR ASSEMBLY	SL
9	48	"G" BASKET SEALING BAR ASSEMBLY	SL



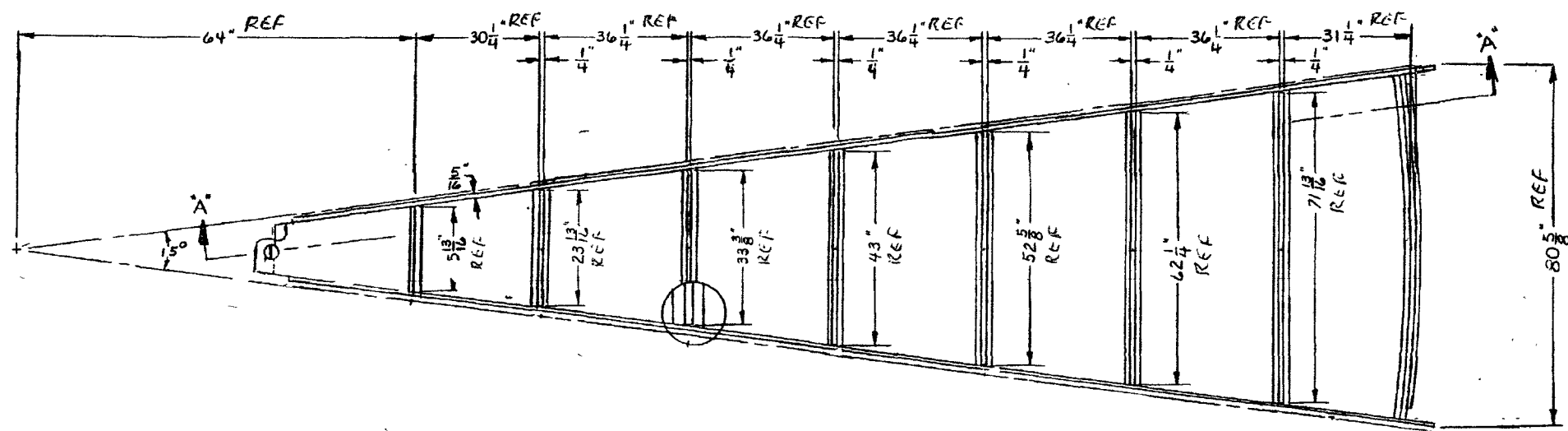
TYPICAL "A" BASKET SEAL ASS'Y

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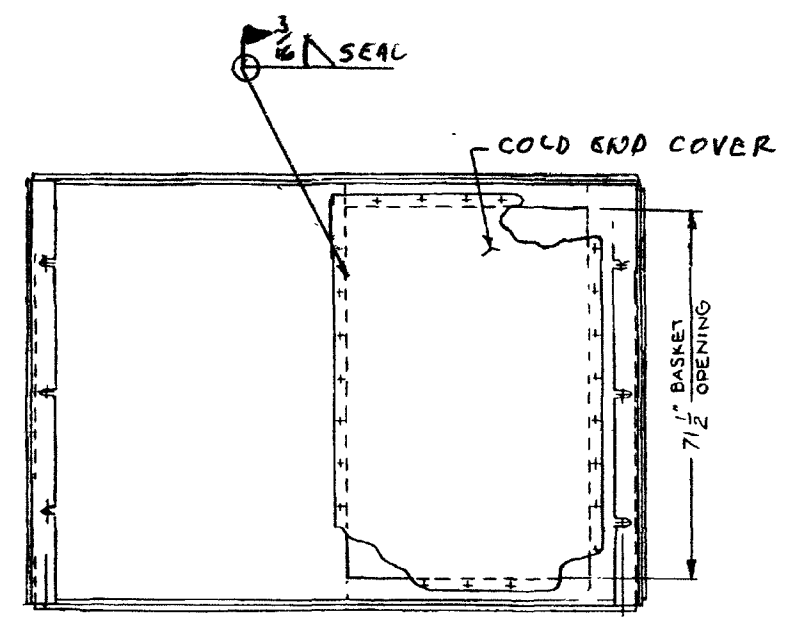
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MARK	DATE	DR.	CK.	COMMENTS
ALTERATIONS				

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		 THIRD ANGLE		ABB AIR PREHEATER, INC. WELLSVILLE, NEW YORK				
	SUBJECT AIR PREHEATER				BASKET SEALING BAR INSTALLATION				
SUPERSEDES	API NO.								
	SIZE 33-1/2 VI								
	DR		CK		CODE	GROUP	SIZE	DWG NO.	REV
	APPR. BY				ER	0204	D	SK-010513	
	DATE 5/13/03				SCALE NTS		WT		SHEET OF

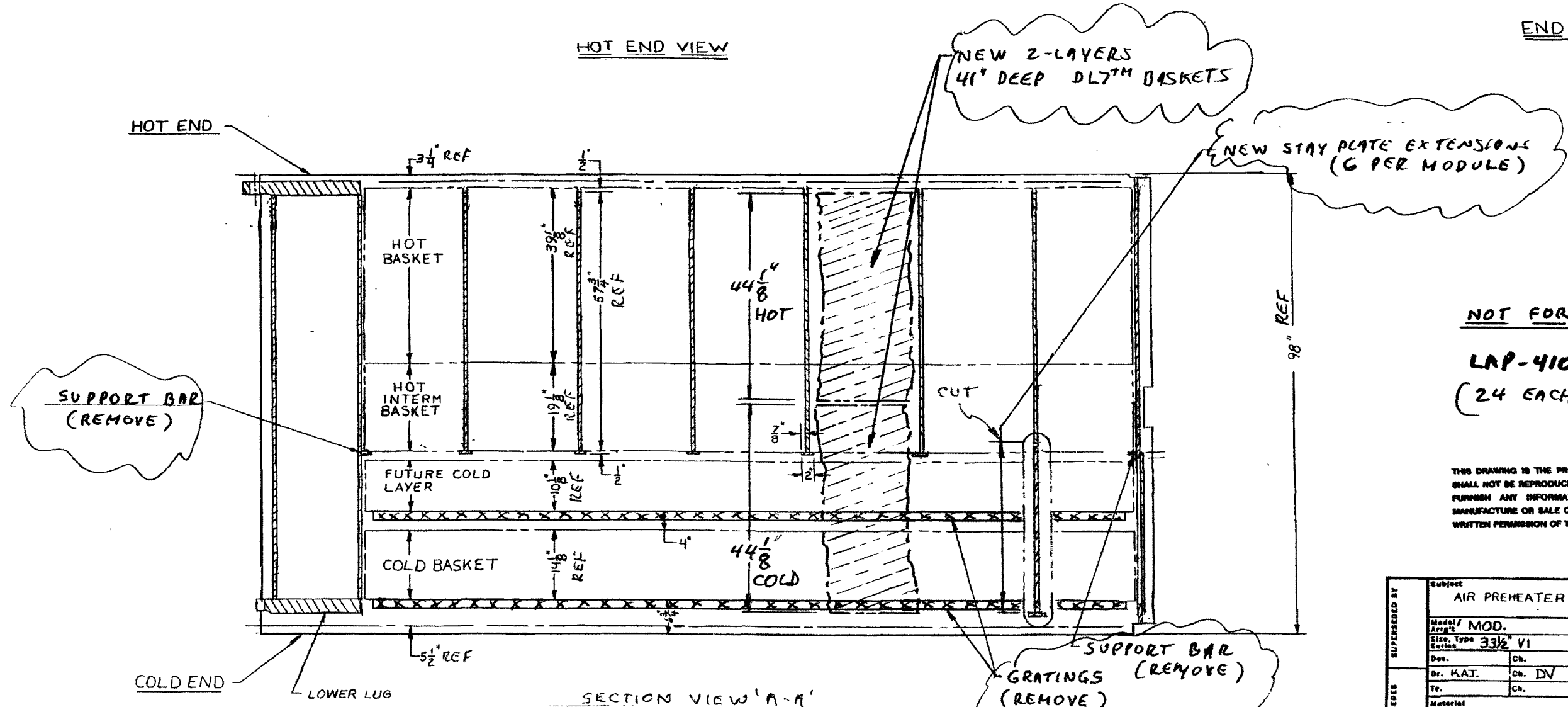




HOT END VIEW



END VIEW




SECTION VIEW 'A-A'

NOT FOR CONSTRUCTION

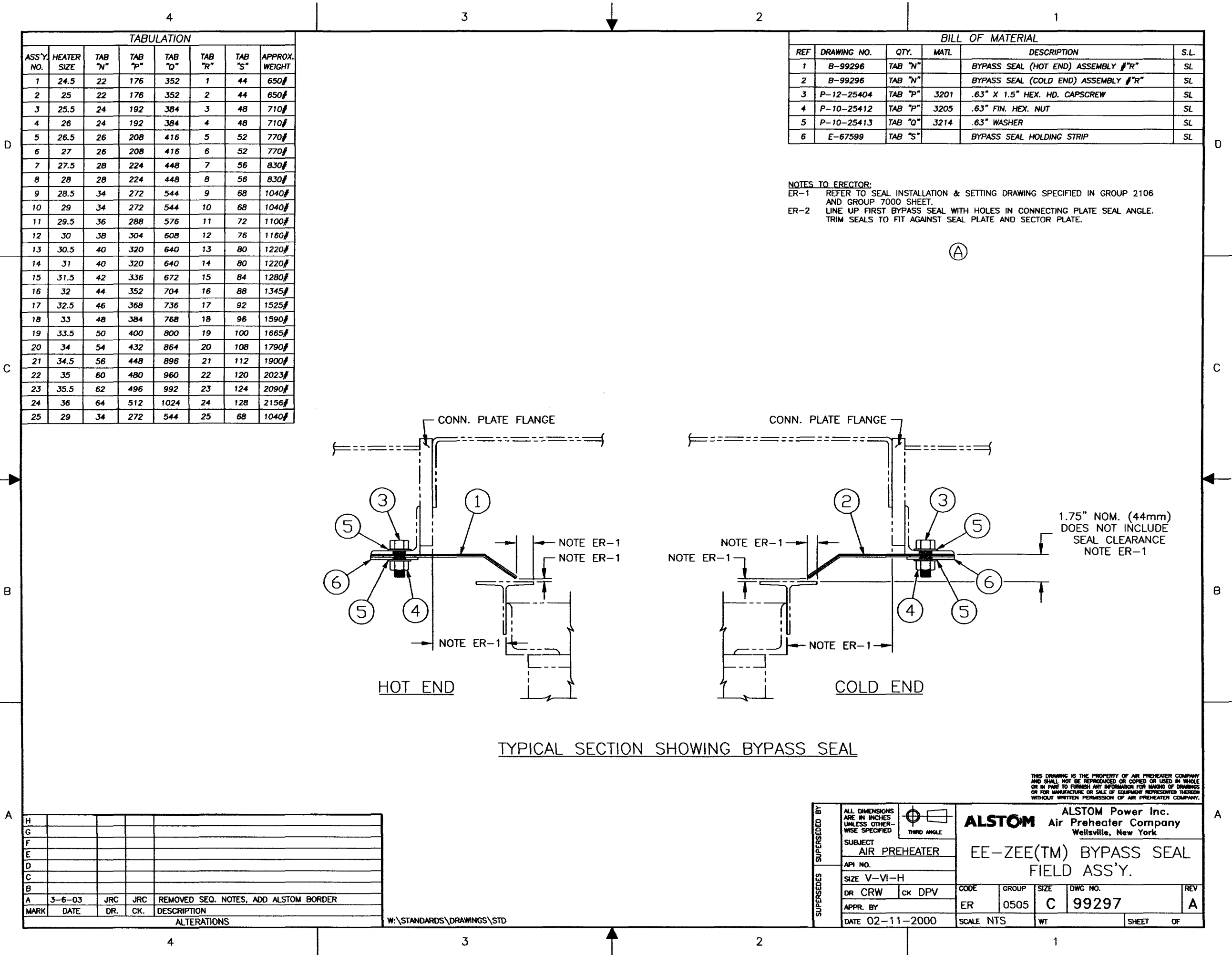
**LAP-4100 EXISTING MODULE**  
(24 EACH AH ROTOR)

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SUPERSEDED BY	Subject AIR PREHEATER		 <b>PROCESS EQUIPMENT</b> CE AIR PREHEATER WELLSVILLE, NEW YORK				
	Model / Arg's MOD.						
	Size, Type Series 33 1/2 VI						
	Des.	Ch.					
SUPERSEDES	Dr. K.A.T.		Ch. DV				
	Tr.		Ch.				
	Material		CODES				
			DRAWING NUMBER				
			80100 ER				
Sht. No.		GROUP	SIZE	NUMBER	ISSU		
DATE 3-10-83		SCALE NTS		0108	A	935435	
				WT.	SHEET		OF



IP7\_033924





**From:** <guy.i.drake@power.alstom.com>  
**To:** Bret Kent <Bret-K@ipsc.com>  
**Date:** 11/12/2003 1:34 PM  
**Subject:** Re: IPSC Lynndyl Unit #2 AH materials, LAP4100  
**CC:** <gary.c.allen@power.alstom.com>

---

Bret,

Most of this information will be included on the new installation drawings. Also, this reference information was sent previously.

**Disassembly:**

1. Drawing 78077, Remove all radial seals, post seals, holding strips and fasteners. Retain diaphragm seals and part numbers 17, 18, 19, 20, 25, 26 (should have straight-edge stored somewhere), 27, 28, 32, 33, 37, 38, 39, 52, 53, 62, 63. If you don't replace t-bars also keep 23, 24, 36 and fasteners for t-bars.
2. Drawing 78075, remove all parts itemized in bill of materials. All new parts furnished.
3. Drawing 99297, remove all parts shown in bill of materials. All new parts furnished.
4. Drawing 935435, individual rotor module (one of 24 per air preheater).  
In each module you will remove hot, hot intermediate and cold end baskets. There are 11 hot end baskets, 11 hot intermediate baskets and 14 cold end baskets in each module (x24). Baskets should be removed and loaded according to the sequence shown on drawing 935428. Once the baskets are removed you will cut each stay plate off (plates between diaphragms), six each module and remove support bars, one at inboard and one outboard per module. You will remove the cold end gratings (support bars under the cold side baskets) two layers in each module. Seal weld 24 existing cold end covers to rotor shell per air preheater.

**Assembly:**

1. Drawing SKETCH 'Rotor Modifications', install all parts as shown in bill of materials and drawing.
2. Load cold end baskets, 14 per module and install sealing bars drawing SK-010513. Load hot end baskets, 14 per module. Load modules according to sequence shown on drawing 935428.
3. Install new radial, post, bypass and axial seals per drawings 78077, 99297, 78075.
4. Set seal gaps according to seal settings sheet with help of radial and axial seal straight-edges, hopefully still on site.

If you still have questions you may want to contact Harlan Finnemore. He's worked on several of these. Thanks.

Guy Drake



**Bret Kent <Bret-K@ipsc.com>**

11/12/2003 09:55 AM

**To:** Guy I. Drake/USWEL01/Power/ALSTOM@GA  
**cc:** Gary C. Allen/USWEL01/Power/ALSTOM@GA  
**Subject:** Re: IPSC Lynndyl Unit #2 AH materials

**Security Level:?** Internal

Guy,

We are finding more question that come up with regard to the scope of work. Do you have a manual or writeup that would cover the following:

- Step by step. What gets torn out.
- How many baskets can be removed on a side before uneven loading is a concern?

**IP7\_033926**

- What items that are torn out need to be put back in. This will help us determine how careful to be, what materials we should have onsite to make repairs to these items...

- Other materials that would be beneficial in describing the scope of work to management.

Thanks for your help,

~~~~~

Bret Kent  
Intermountain Power Service Corp  
850 West Brush Wellman Rd  
Delta, UT 84624

ph. (435) 864-6447  
fx. (435) 864-0747  
[bret-k@ipsc.com](mailto:bret-k@ipsc.com)  
<http://www.intermountainpower.com/>

>>> <guy.i.drake@power.alstom.com> 11/12/2003 7:36:23 AM >>>

Bret,

Rotor angle is attached to the periphery of the rotor shell, hot and cold ends. The t-bars then bolt to the rotor angles. If the rotor angles are in good condition then replacement is not needed. See attached sketch, section B-B, item #1 is t-bar that gets bolted to the rotor angle, hot and cold ends. Hope this helps.

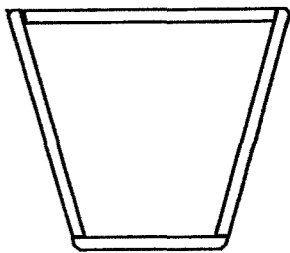
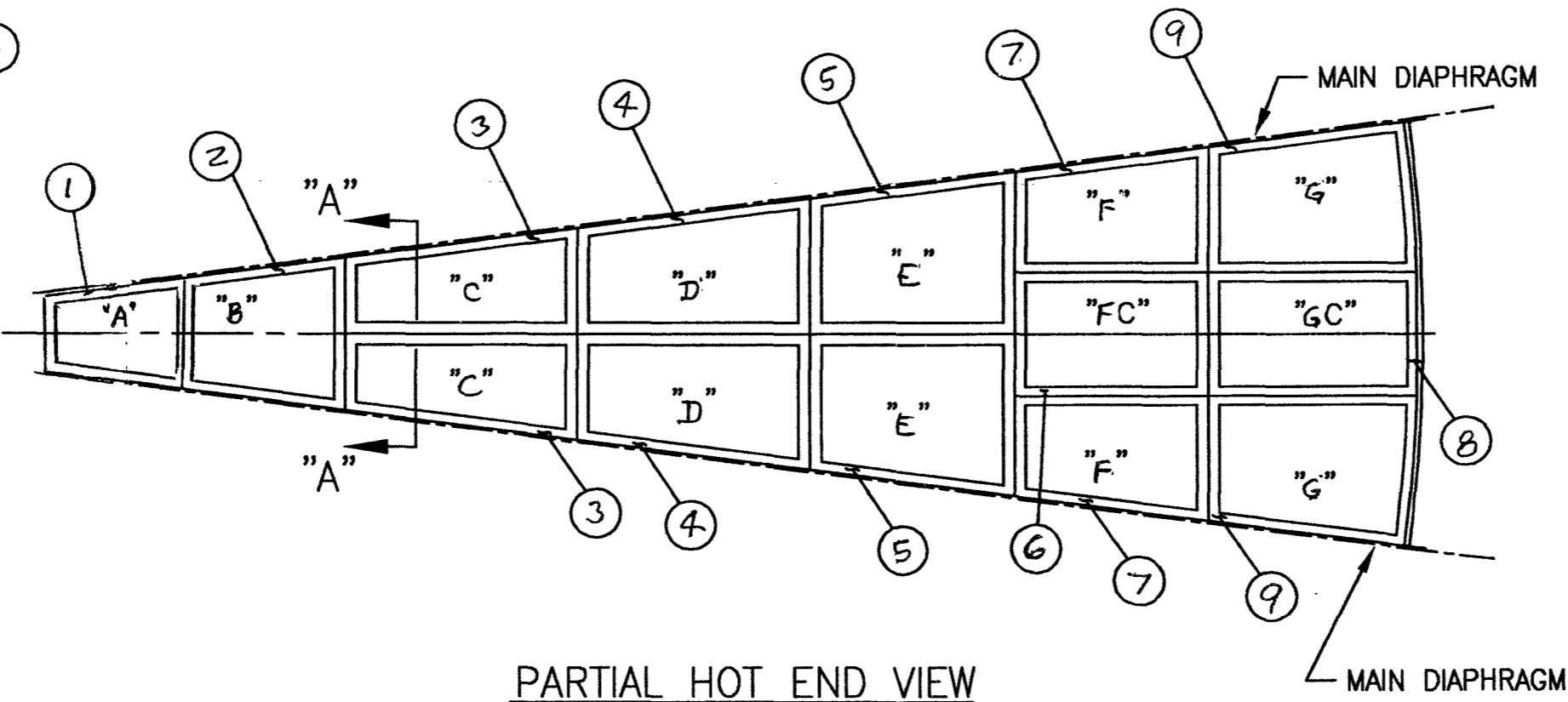
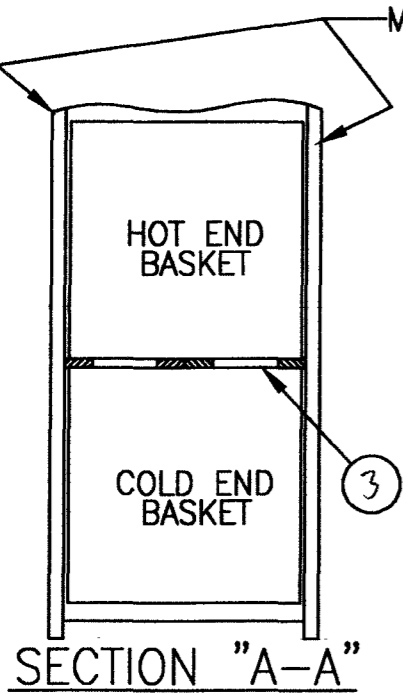
Guy Drake

NOTES TO ERECTOR:

- ER-1) AFTER INSTALLING COLD END BASKETS, INSTALL SEALING BAR ASSEMBLIES BETWEEN HOT AND COLD END BASKETS. DO NOT WELD IN PLACE.
- ER-2) SEALS ARE DESIGNED TO FIT TIGHTLY IN EACH COMPARTMENT IT MAY BE NECESSARY TO SLIDE THE SEAL DOWN AGAINST THE DIAPHRAGM VERTICALLY OR TO ANGLE THE SEAL INTO PLACE. TRIM SEALS TO FIT COMPARTMENT ONLY AS LAST OPTION.
- ER-3) INSTALL HOT END BASKETS.

BILL OF MATERIAL

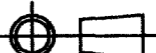

| REF. NO. | REQ'D. | DESCRIPTION                      | SL |
|----------|--------|----------------------------------|----|
| 1        | 24     | "A" BASKET SEALING BAR ASSEMBLY  | SL |
| 2        | 24     | "B" BASKET SEALING BAR ASSEMBLY  | SL |
| 3        | 48     | "C" BASKET SEALING BAR ASSEMBLY  | SL |
| 4        | 48     | "D" BASKET SEALING BAR ASSEMBLY  | SL |
| 5        | 48     | "E" BASKET SEALING BAR ASSEMBLY  | SL |
| 6        | 24     | "FC" BASKET SEALING BAR ASSEMBLY | SL |
| 7        | 48     | "F" BASKET SEALING BAR ASSEMBLY  | SL |
| 8        | 24     | "GC" BASKET SEALING BAR ASSEMBLY | SL |
| 9        | 48     | "G" BASKET SEALING BAR ASSEMBLY  | SL |

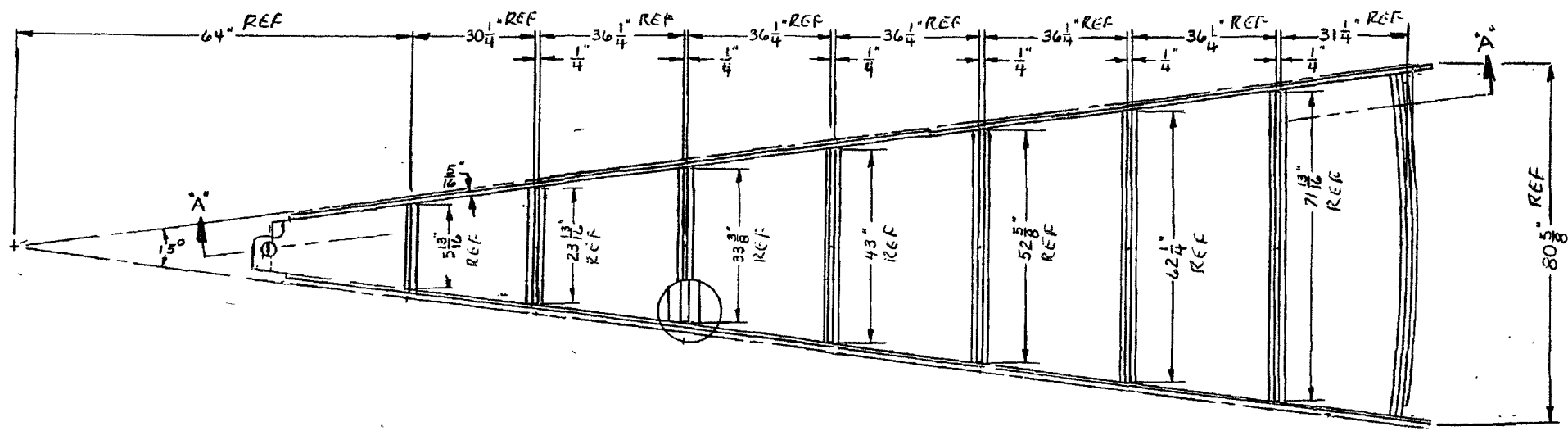


TOP VIEW  
TYPICAL "A" BASKET SEAL ASS'Y

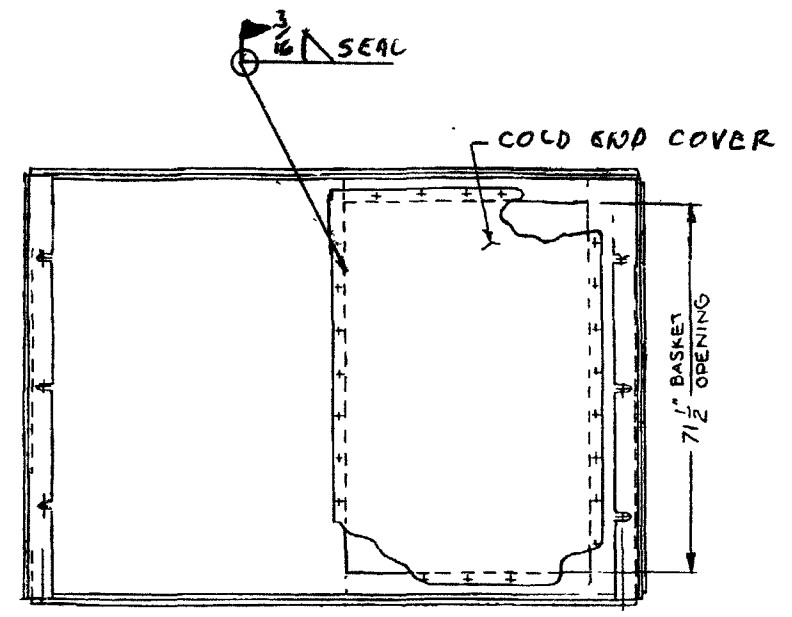
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|             |      |     |     |          |
|-------------|------|-----|-----|----------|
| H           |      |     |     |          |
| G           |      |     |     |          |
| F           |      |     |     |          |
| E           |      |     |     |          |
| D           |      |     |     |          |
| C           |      |     |     |          |
| B           |      |     |     |          |
| A           |      |     |     |          |
| MARK        | DATE | DR. | CK. | COMMENTS |
| ALTERATIONS |      |     |     |          |

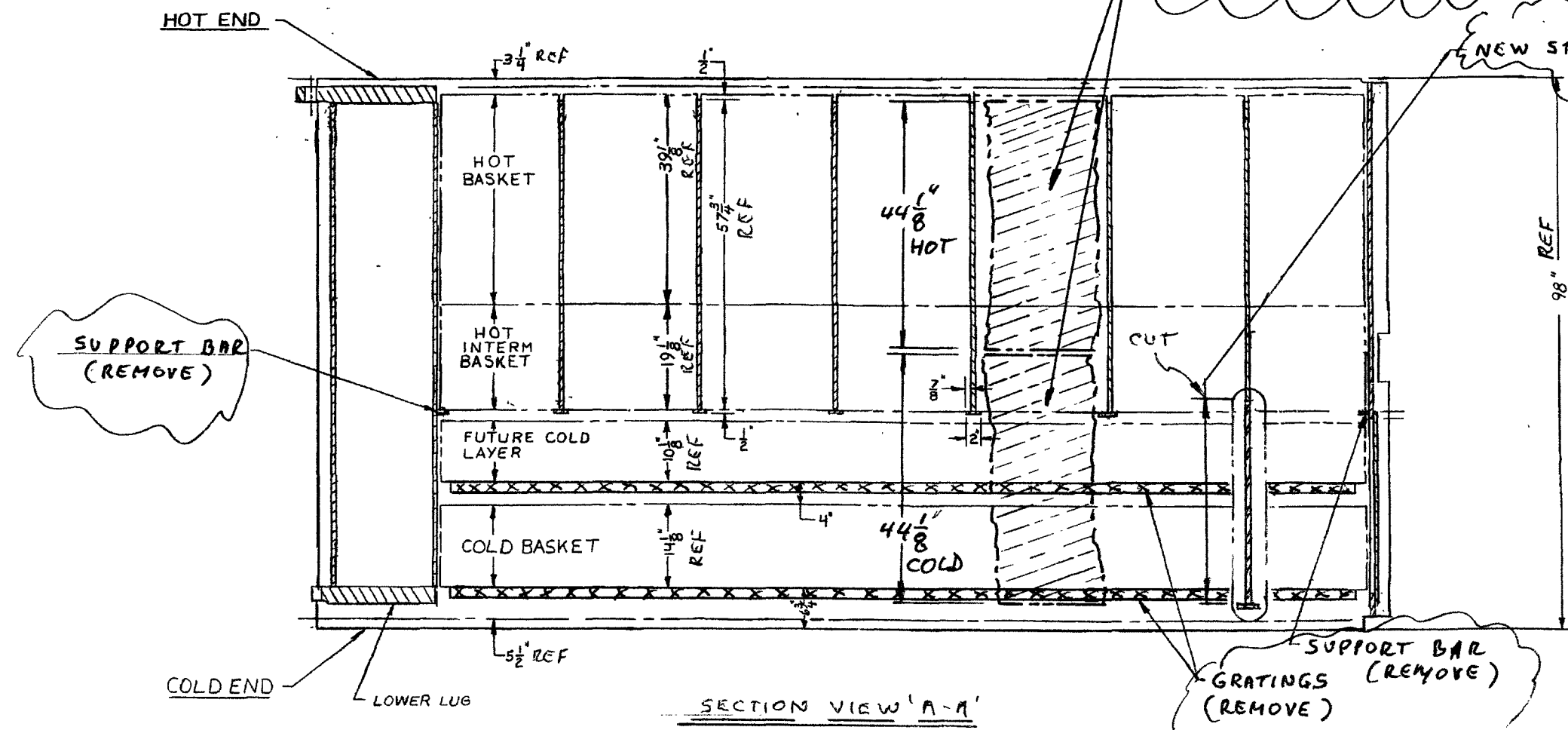
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|---------------|---------------------------------------------------------|--|------------------------------------------------------------------------------------------------------|-----------|---------------------------------------------------------------------------------------------------------------------------------------|-------|-----------|---------|-----|
| SUPERSEDED BY | ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED |  | <br>THIRD ANGLE |           |  ABB AIR PREHEATER, INC.<br>WELLSVILLE, NEW YORK |       |           |         |     |
|               | SUBJECT<br>AIR PREHEATER                                |  |                                                                                                      |           | BASKET SEALING BAR<br>INSTALLATION                                                                                                    |       |           |         |     |
| SUPERSEDES    | API NO.                                                 |  |                                                                                                      |           |                                                                                                                                       |       |           |         |     |
|               | SIZE 33-1/2 VI                                          |  |                                                                                                      |           |                                                                                                                                       |       |           |         |     |
|               | DR                                                      |  | CK                                                                                                   |           | CODE                                                                                                                                  | GROUP | SIZE      | DWG NO. | REV |
| APPR. BY      |                                                         |  |                                                                                                      | ER        | 0204                                                                                                                                  | D     | SK-010513 |         |     |
| DATE 5/13/03  |                                                         |  |                                                                                                      | SCALE NTS |                                                                                                                                       | WT    |           | SHEET   | OF  |



HOT END VIEW



END VIEW




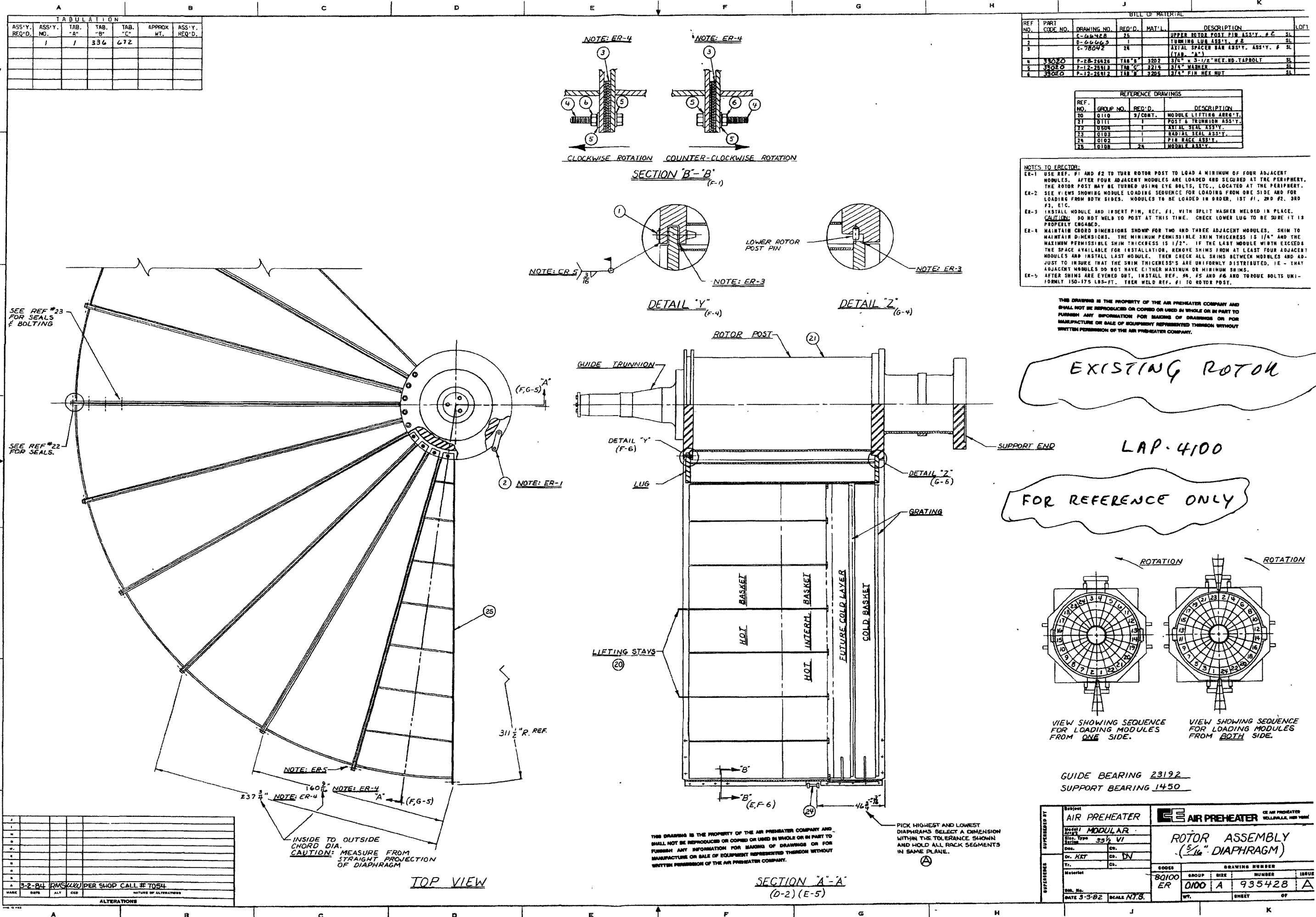
SECTION VIEW 'A-A'

NOT FOR CONSTRUCTION

**LAP-4100 EXISTING MODULE**  
(24 EACH AH ROTOR)

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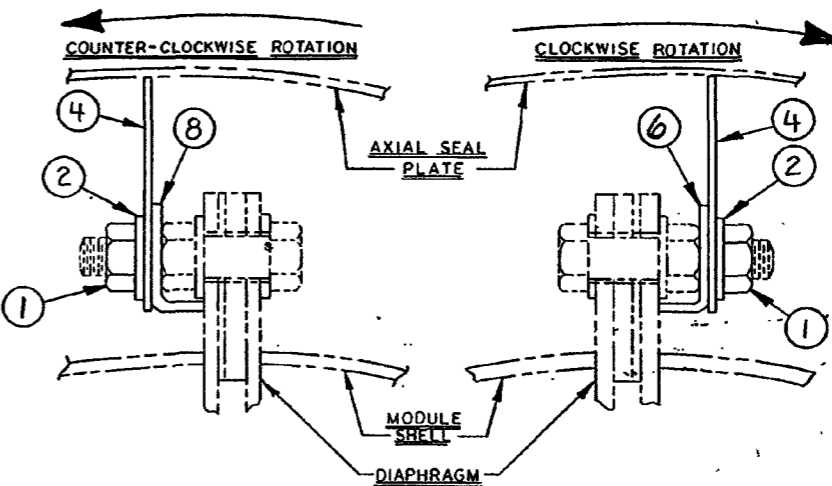
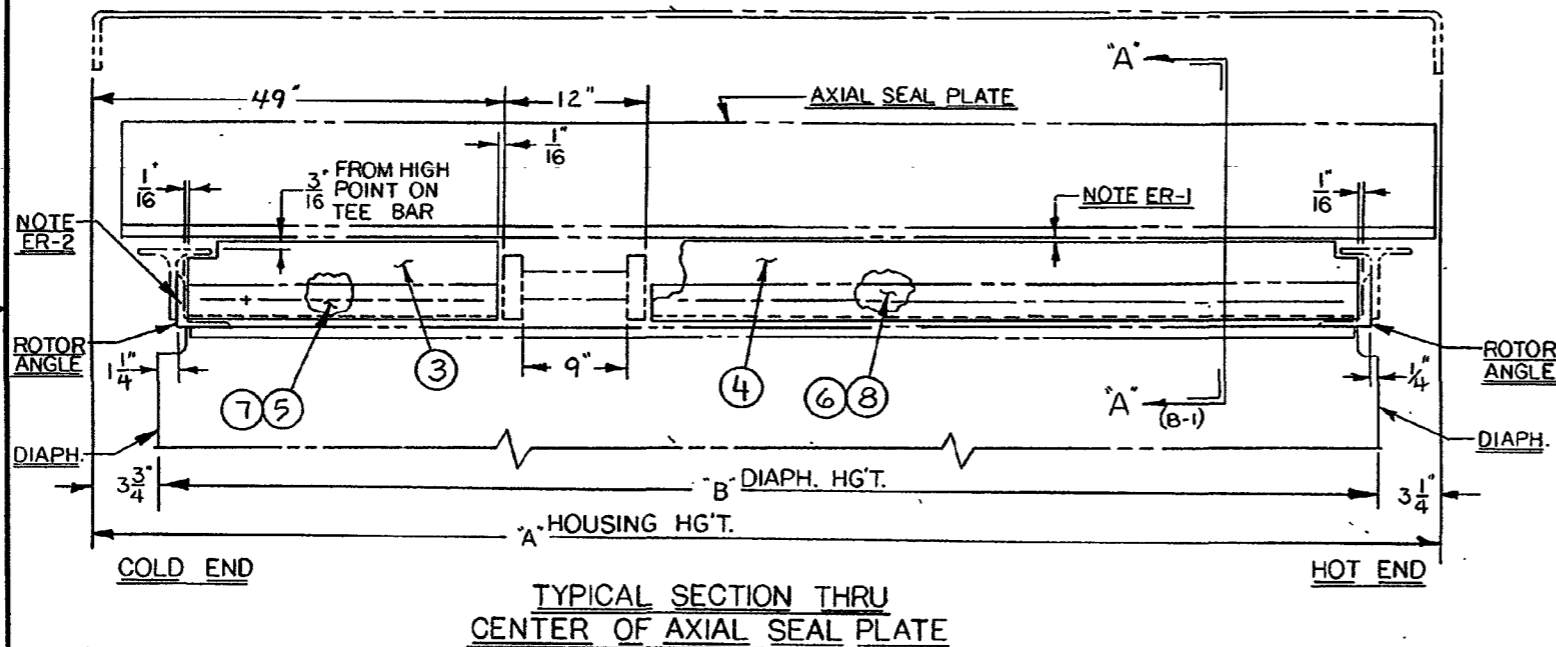
|               |                                 |              |                                                                                                                                                            |  |  |
|---------------|---------------------------------|--------------|------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|
| SUPERSEDED BY | Subject<br>AIR PREHEATER        |              |  <b>PROCESS EQUIPMENT</b><br>CE AIR PREHEATER<br>WELLSVILLE, NEW YORK |  |  |
|               | Model /<br>A/RITE MOD.          |              |                                                                                                                                                            |  |  |
|               | Size, Type<br>Series 33 1/2" VI |              |                                                                                                                                                            |  |  |
|               | Des. Ch.                        |              |                                                                                                                                                            |  |  |
| SUPERSEDES    | Dr. KAT. Ch. DV                 |              | MODULE ASSEMBLY<br><br>LAP-4100                                                                                                                            |  |  |
|               | Tr. Ch.                         |              |                                                                                                                                                            |  |  |
|               | Material                        |              |                                                                                                                                                            |  |  |
|               | Sht. No.                        |              |                                                                                                                                                            |  |  |
|               | DATE 3-10-83                    |              |                                                                                                                                                            |  |  |
| SCALE NTS     |                                 | WT. SHEET OF |                                                                                                                                                            |  |  |



| TABULATION    |            |         |         |         |         |         |         |         |              |
|---------------|------------|---------|---------|---------|---------|---------|---------|---------|--------------|
| ASS'Y. REQ'D. | ASS'Y. NO. | TAB "A" | TAB "B" | TAB "C" | TAB "E" | TAB "F" | TAB "G" | TAB "H" | APPROX. WGT. |
| 1             | 105        | 98      | 336     | 1       | 2       | 7       | 8       |         |              |
| 2             |            |         |         |         |         |         |         |         |              |
| 3             |            |         |         |         |         |         |         |         |              |

| BILL OF MATERIAL                                   |               |             |        |        |                                 |      |
|----------------------------------------------------|---------------|-------------|--------|--------|---------------------------------|------|
| REF. NO.                                           | PART CODE NO. | DRAWING NO. | REQ'D. | MAT'L. | DESCRIPTION                     | LOFT |
| 1                                                  | 32050         | P-12-25412  | "C"    | 3205   | 3/4" FIN. HEX. NUT              | SL   |
| 2                                                  | 32140         | P-12-25413  | "C"    | 3214   | 3/4" WASHER                     | SL   |
| 3                                                  |               | D-E-78076   | 24     |        | AXIAL SEAL LEAF (COLD END)      | SL   |
| 4                                                  |               | D-F-78076   | 24     |        | AXIAL SEAL LEAF (HOT END)       | SL   |
| THE FOLLOWING TO BE FOR CLOCKWISE ROTATION         |               |             |        |        |                                 |      |
| 5                                                  |               | D-G-76118   | 24     |        | FORMED HOLDING STRIP (COLD END) | SL   |
| 6                                                  |               | D-H-76117   | 24     |        | FORMED HOLDING STRIP (HOT END)  | SL   |
| THE FOLLOWING TO BE FOR COUNTER-CLOCKWISE ROTATION |               |             |        |        |                                 |      |
| 7                                                  |               | D-G-76117   | 24     |        | FORMED HOLDING STRIP (COLD END) | SL   |
| 8                                                  |               | D-H-76118   | 24     |        | FORMED HOLDING STRIP (HOT END)  | SL   |

NOTES TO ERECTOR:  
 ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106.  
 ER-2 NOTCH FORMED HOLDING STRIP TO FIT AT ASSEMBLY.




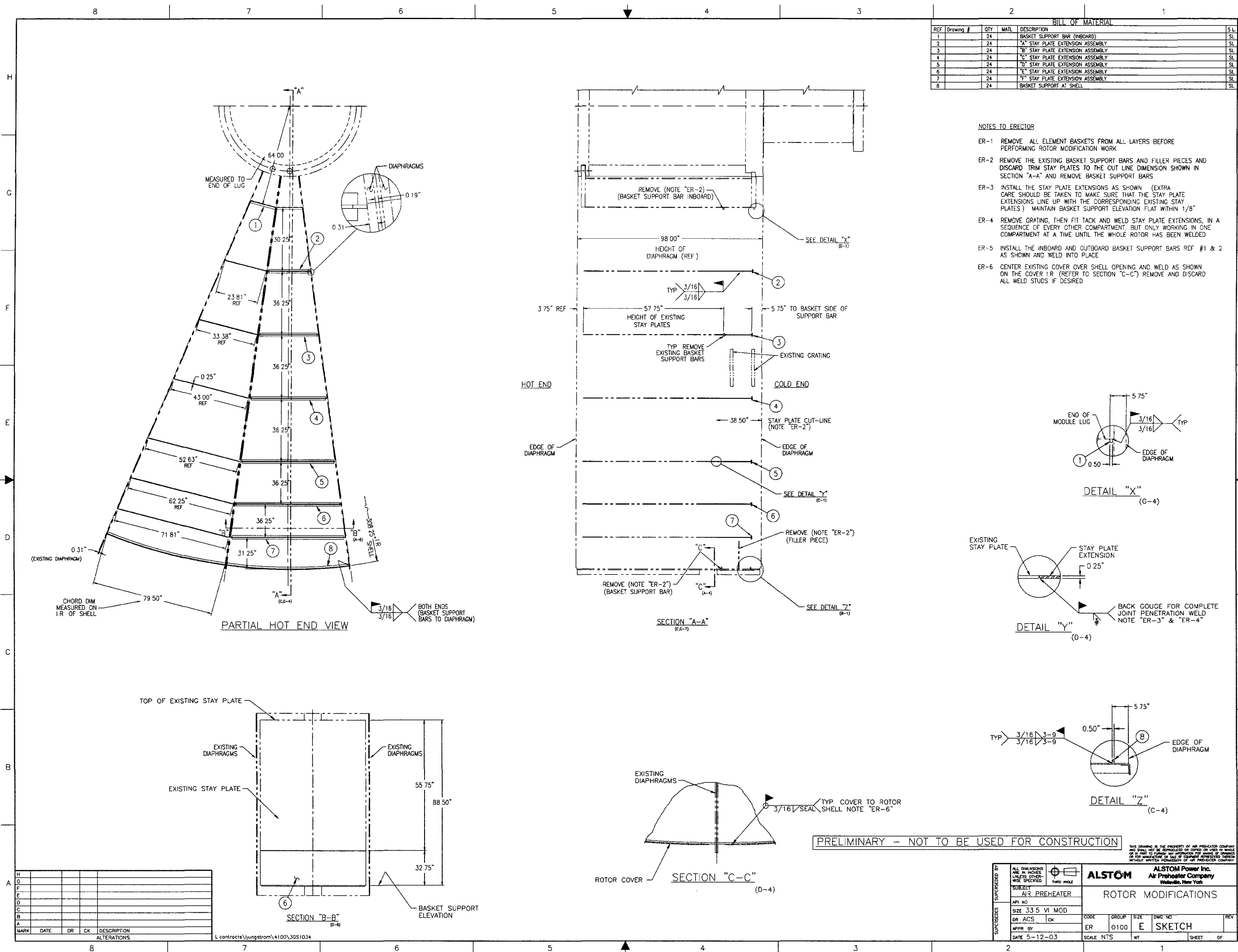
SECTION "A-A" (B-3)  
 AS VIEWED FROM HOT END

2 LAYER SIDE REMOVAL - DEF. SECTOR PL.

| MARK | DATE | ALT. | CKD. |
|------|------|------|------|
| J    |      |      |      |
| I    |      |      |      |
| H    |      |      |      |
| G    |      |      |      |
| F    |      |      |      |
| E    |      |      |      |
| D    |      |      |      |
| C    |      |      |      |
| B    |      |      |      |
| A    |      |      |      |

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|               |                                      |           |                                                                                                            |                                          |                |        |        |       |  |
|---------------|--------------------------------------|-----------|------------------------------------------------------------------------------------------------------------|------------------------------------------|----------------|--------|--------|-------|--|
| SUPERSEDED BY | Subject<br>AIR PREHEATER             |           |  PROCESS<br>EQUIPMENT | CE AIR PREHEATER<br>WELLSVILLE, NEW YORK |                |        |        |       |  |
|               | Model /<br>Alt. MOD.                 |           |                                                                                                            | AXIAL SEAL ASSEMBLY                      |                |        |        |       |  |
|               | Size, Type<br>Series 32 1/2 - 34 VI. |           |                                                                                                            | 9"-CLEAR PIN LENGTH                      |                |        |        |       |  |
|               | Des.                                 | Ch.       |                                                                                                            |                                          |                |        |        |       |  |
| SUPERSEDES    | Dr. KAT                              |           | Ch. DV                                                                                                     |                                          |                |        |        |       |  |
|               | Tr.                                  |           | Ch.                                                                                                        |                                          |                |        |        |       |  |
|               | Material                             |           | CODES                                                                                                      |                                          | DRAWING NUMBER |        |        |       |  |
|               | Stk. No.                             |           | ER                                                                                                         |                                          | GROUP          | SIZE   | NUMBER | ISSUE |  |
| DATE 3-15-83  |                                      | SCALE NTS |                                                                                                            | 80100<br>(M)                             |                | 0504 C |        | 78075 |  |
|               |                                      |           |                                                                                                            | WT.                                      |                | SHEET  |        | OF    |  |





A

1.75" NOM. (44mm)  
DOES NOT INCLUDE  
SEAL CLEARANCE  
NOTE ER-1

**M.**

4

1

Ⓐ

2

DATE 02-11-2000

|       |     |    |       |    |
|-------|-----|----|-------|----|
| SCALE | NTS | WT | SHEET | OF |
|-------|-----|----|-------|----|

A